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STONE'S

PARAMOUNT CUTTER

A System for Cutting Garments,

BASED UPON SCIENTIFIC PRINCIPLES, INCLUDING THE SELF-VARYING SHOULDER, IN
CONNECTION WITH THE DIVISION OF THE BREAST-MEASURE.

) Third Edition Revised (

By
Chas. J. Stone.

Chicago, Ill.

ILLUSTRATED BY SEVENTEEN PLATES OF FINELY ENGRAVED DIAGRAMS AND ONE PROPORTION
TABLE WITH FULL INSTRUCTIONS FOR DRAFTING THE VARIOUS
STYLES OF GENTLEMEN'S GARMENTS.

PUBLISHED BY

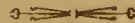
The Chas. J. Stone Co. Cutting School,

CHICAGO.



—STONE'S—

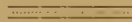
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CHAS. J. STONE,

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Illustrated by Seventeen Plates of finely Engraved Diagrams and One Proportion Table
with full instructions for Drafting the various Styles
of Gentlemen's Garments.



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Yours Truly
Chas. J. Stone

❧ P R E F A C E . ❧

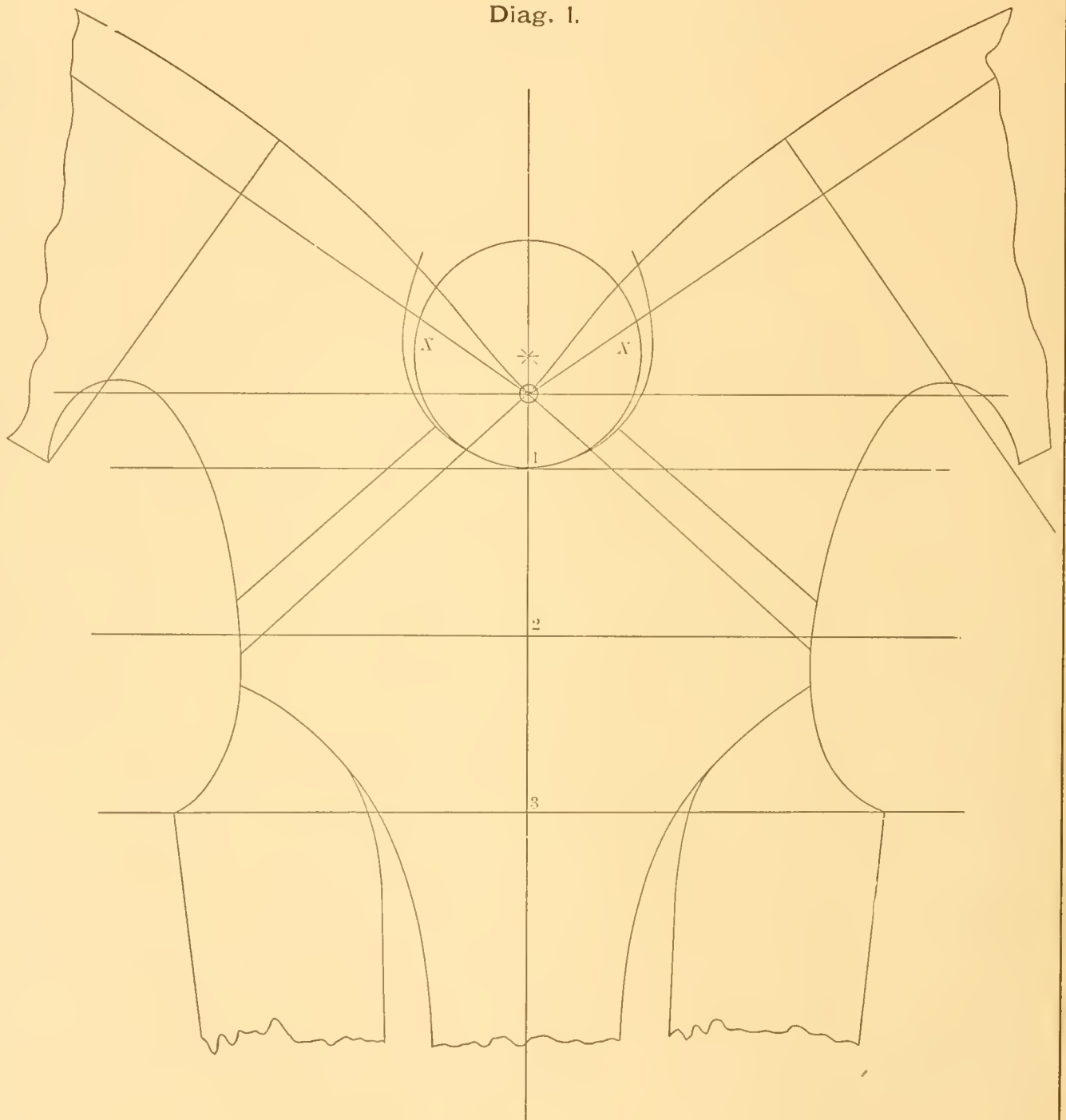


IN placing the Third Edition, revised, of the Paramount Cutter before the trade I herewith tender my thanks for the warm reception given the first and second editions of this work. This, the third edition has been enlarged, revised and simplified. The principles here laid down are the result of years of practical experience and with the most satisfactory results. The Diagrams illustrating the principles set forth have been drawn by myself and engraved under my personal supervision with the utmost care and are calculated to demonstrate accurate instructions, made so plain that anyone who will give this system a careful study will find the entire work one of the most reliable on the subject that has ever been offered to the trade. While every page of this book is the result of my own reflection and the experience of many years at the Cutting Board, it is also proper to state that I have consulted with many of our Finest Artists, both in this country and Europe, in order that the present work might embrace the modern and most approved methods on Garment Cutting. The work commences with the production of properly fitting and correctly balanced garments for the normal figure. A master knowledge of the business is acquired by first qualifying ourselves in the knowledge of producing a *Fit* for a normal shape, and in the next place to change correctly from the regular to fit and conform to the various changes as we meet them in every day practice. This I clearly illustrate in my Self Varying Shoulder Measure.

In conclusion, let all those who intend to study and practice these new principles lay aside all prejudice and follow out the instructions as herein given, and in so doing, you will find that *complete success will follow* and you will become a hearty endorser of this valuable work.

THE AUTHOR.

Diag. 1.



EXPLANATION OF DIAGRAM 1.

I now invite your careful attention to the principles which govern Coat Cutting. In order to make this as plain as possible I have designed Diagram 1, showing the Neck and Shoulders and locating the shoulder point. This point is looked upon by most cutters as the key to the whole Coat Cutting, and I must say that I never saw any system that located this point to any certainty. In my younger days I paid out hundreds of dollars to the most successful cutters for instructions on the shoulder point, and they always gave it to me *about* right; but there was a good deal of guess-work about it for different shapes, and I never discovered the shoulder point until a few years ago, when in company with a young doctor friend of mine I attended a lecture (or clinic) on anatomy, and in the professor's lecture to the students on the human skeleton, explaining every part of the body, I concluded that I had at last found the shoulder point; and when I came home I put it into practice and found it to be correct. I will now explain this point. The round ring where all lines meet is the centre of the body, but as you will observe by looking at any well built man you will find that his head is not on the centre of the body, but one twenty-fourth of the breast forward, locating the centre of neck where the star is; the neck is one-third of breast, from x to x, making it a circle of one-sixth; from 1 to 2 is $\frac{1}{4}$ of breast, and from 1 to 3 is $\frac{1}{2}$ of breast. Now, as the neck gorge wants to follow the shirt collar it must be cut down in front as represented. This will clearly show you how to get the shoulder point, and you can rely on it every time. The shoulder point will always be the same for all shapes, as a No. 15 collar will fit that size neck no matter what kind of a shoulder the man has, high or low. The neck gorge must be the same size from x to x, as a man's neck is. See Diagram 9 for long and short necks, and Diagram 10 for very erect and very stoop shoulder, regulated by the self-varying shoulder.

EXPLANATIONS OF DIAGRAM 2.

NOTE:—In Drafting Coats I always use $\frac{1}{2}$ of Breast and when I say $\frac{1}{4}$, $\frac{1}{3}$, $\frac{1}{2}$, or $\frac{1}{6}$, it is that amount of half the Breast measure and the Divisions is found on any ordinary square used by cutters.

D. B. FROCK.

First draw line from A. to E. and square out from A. to H.

From A. to B. is $\frac{1}{4}$, and to C. is $\frac{1}{2}$; to D. is the hollow of waist and to E. is the fashionable length.

Square out lines B. C. D. and E.

From C. to G. is half of Breast, and to N. is $2\frac{1}{4}$ inch.

G. to I. line 14, is $\frac{1}{3}$ and from I to 2 is $\frac{1}{4}$.

Square up lines 1 and 2.

Line 14 is $\frac{3}{4}$ inch below Breast line 13.

A. to 11 is $\frac{1}{8}$ and D. to 7 is $\frac{1}{8}$, or whatever style calls for.

Draw line from 1 to 11 and from B. to H.

Draw constructions or guide line from 7 to half inch forward of 11; also from 10 to E.

Shape back as shown in Diagram, making width of back at 15, half way between V. and X., and coming down same distance to 9.

Take out one twenty-fourth between back and side body (7 to 6): also one twenty-fourth is taken out between 4 and 5, in all cases.

Take out $\frac{5}{8}$ inch between back and side body (8 to 9).

One-quarter inch is taken out between back and side body on Breast line C.

Shape side body as shown in Diagram, making it one seam longer at bottom. I.

From C to 3 is $\frac{1}{2}$ and half inch.

D. to 4 is $\frac{1}{2}$ less half inch.

H. to 12 is $\frac{1}{6}$.

Sweep from I. to K. by 12 for length in front.

K. is one-twenty-fourth forward from breast line.

Shape front centre line from H. through N. M. to K.

For a D. B. Frock take off $\frac{1}{2}$ inch at O. to nothing at N.

Cut out back and place Point 11 on Point 12, and let the two lines from 1 to 11, and from B. to H. run parallel with one-another and mark off shoulder same as dotted line, then shape shoulder, neck gorge and armseye as shown in Diagram, coming forward to line 13. $\frac{3}{4}$ inch from lines 1 and 14.

From H. to O. is $\frac{1}{4}$, always, being the depth of neck gorge.

Shape lapell as shown in Diagram.

For a small waisted coat do not reduce anything in front at M. P. K., but reduce the waist at 5.

For a large waist add all in front at M. P. K.

HOW TO CUT A SKIRT.

P. is half way between M. and K.

Draw straight line back from P.

7 to S. is $\frac{1}{2}$ of length of natural waist, or half the distance from A. to D.

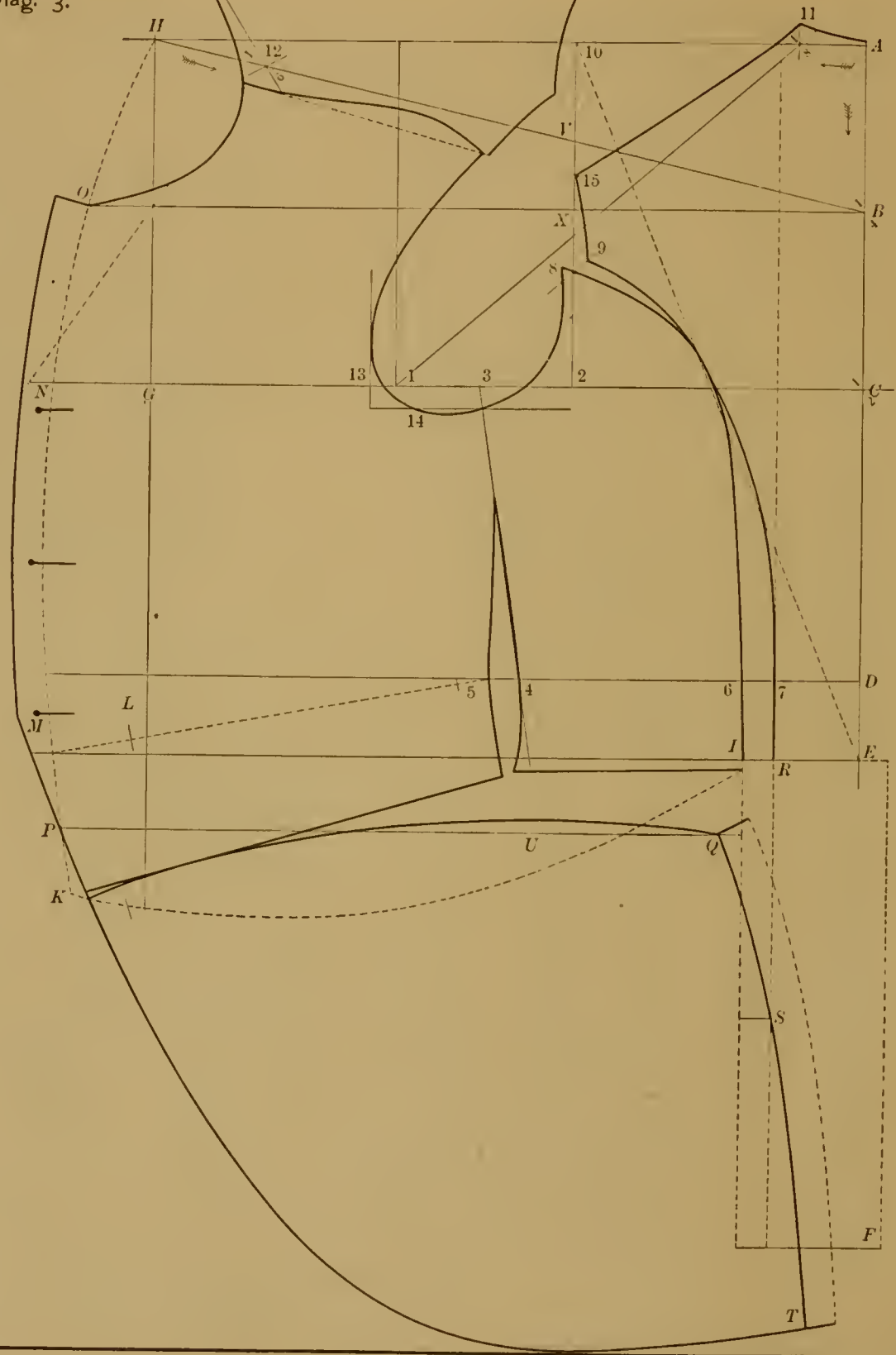
Width of skirt from K. to Q. is $\frac{1}{4}$ inch more than fore part and sidebody from K. to L.

Shape skirt raising it $\frac{5}{8}$ inch at U.

Q. to T. is the same as E. to F. and L. to T.

Draw straight line from F. to T. and make it $\frac{1}{2}$ inch longer in centre shape as drawn in Diagram.

Diag. 3.



EXPLANATION OF DIAGRAM 3.

NOTE :—This Coat is cut by the following measures : Breast, 38, waist 37, Seat 39, length of waist, 17, fashionable length of waist, 10.

DIRECTIONS HOW TO DRAFT.

First, square lines from A to E and to H.

A to B is $\frac{1}{4}$ and to C. $\frac{1}{2}$.

To D E and F according to measure.

From C to G $\frac{1}{2}$ of Breast (19 inches).

G to N is $2\frac{1}{4}$ inch.

G to 1 is $\frac{1}{3}$ and from 1 to 2 is $\frac{1}{4}$.

Square up lines 1 and 2.

From 1 to 13 is $\frac{3}{4}$ inch, and from 1 to 14 also $\frac{3}{4}$ inch.

From A to 11 is 18.

Raise back $\frac{5}{8}$ inch at 11.

Draw line from 1 to 11 and from B to H.

H to 12 is $\frac{1}{6}$.

15 is half way between V and X.

D to 7 is 18. Shape back as shown in diagram.

The dotted lines drawn from $\frac{1}{2}$ inch in front of 11 to 7, and from 10 to E are used as guide lines.

From 7 to 6 is one twenty-fourth and 4 to 5 is one twenty-fourth in all cases.

8 to 9 is $\frac{5}{8}$ inch.

Make side body one seam longer at I.

Sweep from I to K by 12.

Apply $\frac{1}{2}$ of waist measure from D to L on dotted line.

Add 2 inches from L to M.

Draw front centre line from H through N, M, P and K.

This will make the correct front for a D B Frock coat.

Cut out the back and place Point 11 ($\frac{1}{8}$) on Point 12 ($\frac{1}{6}$) letting line 1-11 run on top of line H B.

Shape coat as shown in Diagram from H to O is $\frac{1}{4}$ in all cases.

For a three button cut away coat add at N and M one inch for a coat that is to be bound edges, and $1\frac{1}{4}$ inches if the edges are to be turned in.

HOW TO DRAFT A SKIRT.

Draw a straight line from P to Q.

P is half way between M and K.

Make width of skirt from K to Q $\frac{1}{4}$ inch wider than forepart, and side body is from K to L.

From 7 to S is one-half the length of natural waist.

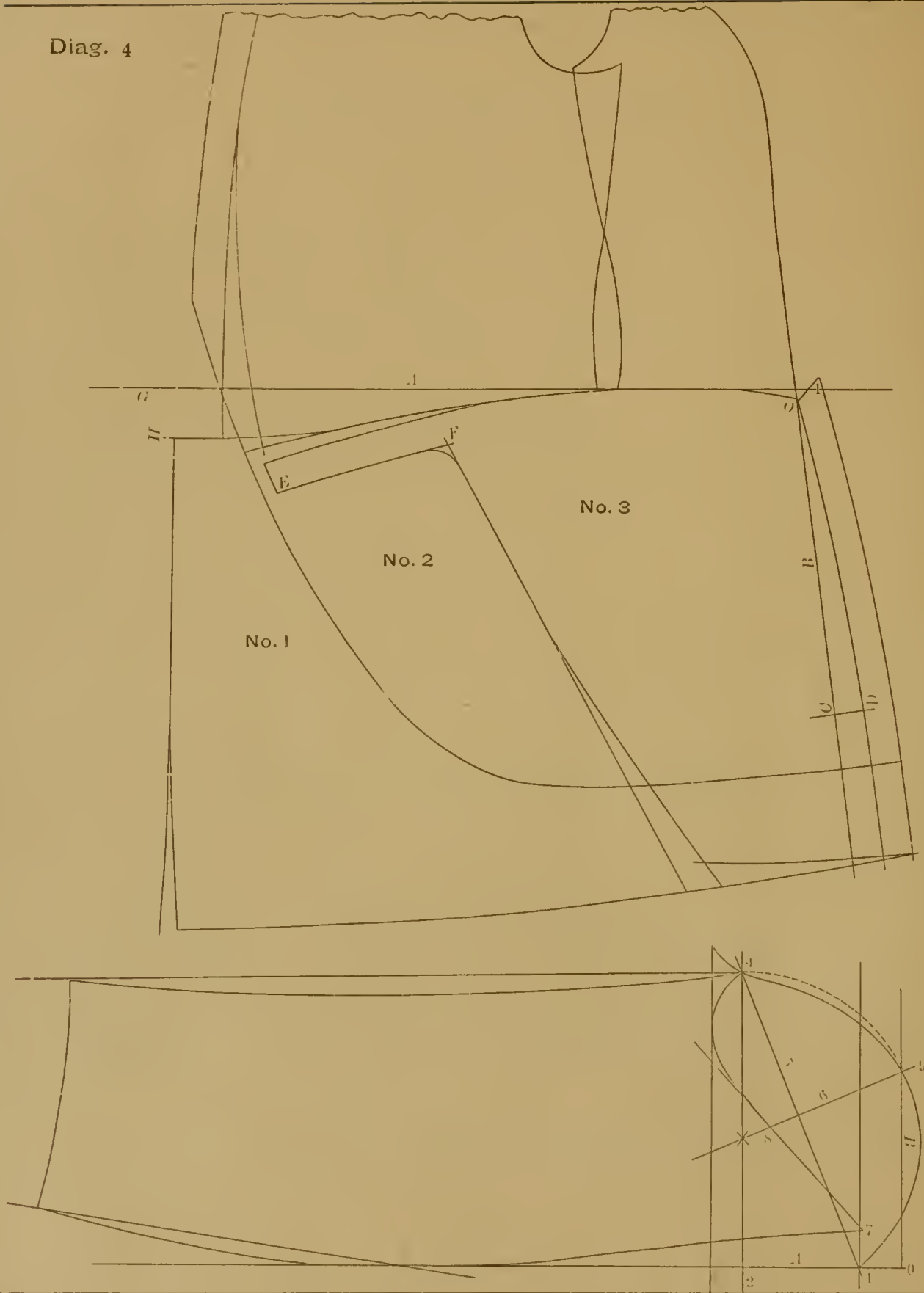
Shape skirt as shown in Diagram, raising it $\frac{3}{8}$ inch at U.

HOW TO REGULATE THE SPRING.

A proportionate or normal figure will measure one inch more around the seat than breast, as follows: 36 B, 32 W, 37 S. Now if the seat measure is 38, add to spring of skirt at S $\frac{3}{8}$ inch, and if the seat is 36 reduce the spring at S $\frac{1}{4}$ inch. Increase the spring $\frac{3}{8}$ inch for every inch it is over normal and decrease it $\frac{1}{4}$ inch for every inch it is less than normal.

This will regulate the spring in both frock and sack coats, and it will never fail if the measure is taken correctly.

Diag. 4



EXPLANATION OF DIAGRAM 4.

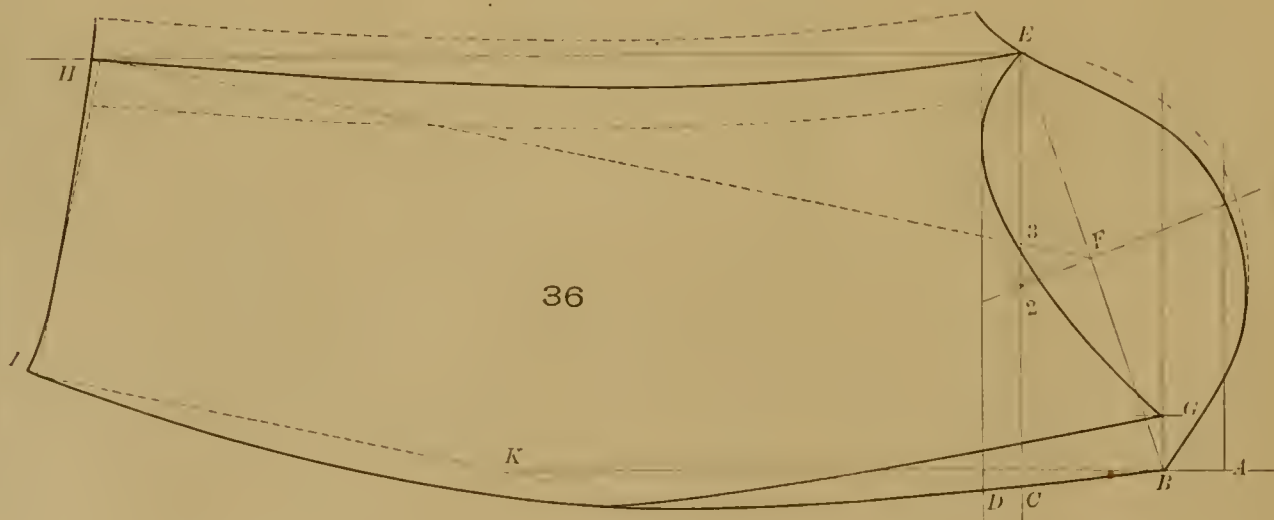
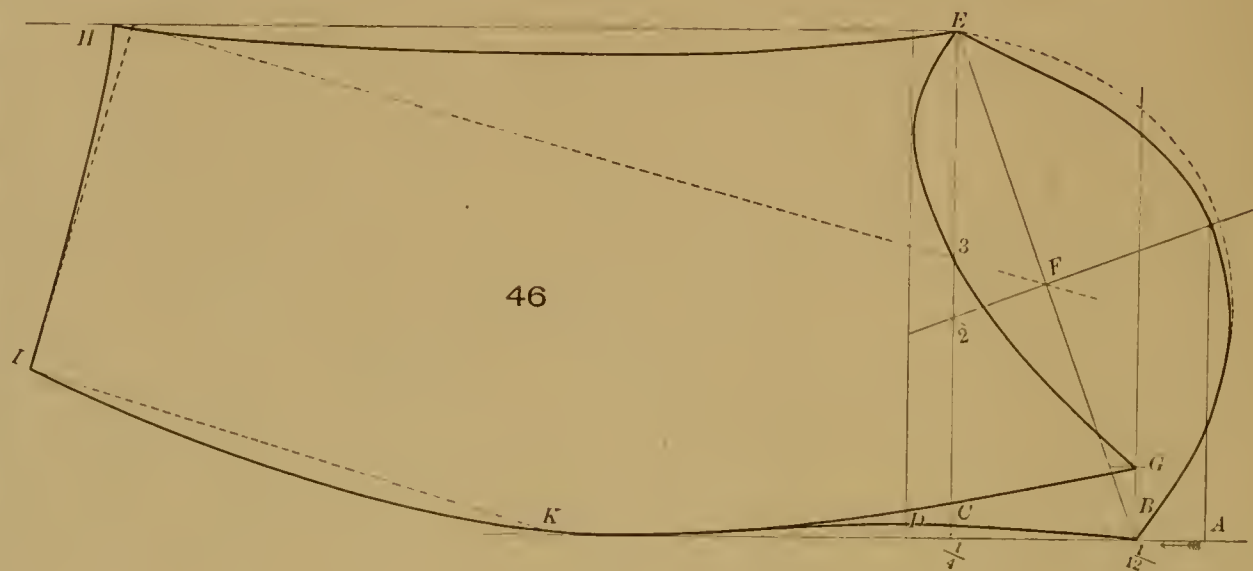
ANOTHER METHOD OF CUTTING A SKIRT.

Draw straight line A, then place side body and forepart as shown in Diagram. Drop from G to H $\frac{1}{2}$ of the upper hip measure and shape top of skirt as shown in the Diagram, dropping down $\frac{1}{4}$ inch at O, then draw line B, by placing the straight edge parallel with the side body from O to C is $\frac{1}{2}$ of the length of the waist of Coat, from C to D is $\frac{1}{6}$ of the hip measure, this will give the correct spring to skirt, as if a man takes a large hip measure he requires a large spring, if a small hip measure he takes a small spring, etc. - for proportion the hip measure should be 1 inch more than the breast measure. No. 1 shows the style of a P. A. skirt. No. 2 shows the cut-away skirt, and No. 3 shows how to cut a dress coat skirt; the dress coat skirt must be cut down $\frac{1}{2}$ inch more at E, making it $\frac{1}{2}$ and $\frac{1}{2}$ inch from straight line A, to top of skirt at E, from E to F is $\frac{1}{3}$ the distance from E to O. Make the width of the skirt at bottom $\frac{1}{3}$ or the same as from E to F; shape as shown in Diagram. Make skirt $\frac{1}{2}$ inch wider than the forepart or fullness over hip.

HOW TO CUT A SLEEVE.

Square lines A and B, go down from O to 1 is $\frac{1}{2}$, and from O to 2 is $\frac{1}{4}$, from 2 to 3 is $\frac{3}{4}$ inch. Square lines 1, 2 and 3. To find the proper width of sleeve, add your armscye measure to $\frac{1}{2}$ of breast measure, say 36 coat and 16 armscye, 16 and 18 are 34; take $\frac{1}{4}$ of 34 for the width of arm, making it $8\frac{1}{2}$ inches from 1 to 4 on slanting line 5. Line 6 is half way between 1 and 4. Square line 6 up and down by line 5; 8 is half way between line 5 and the star. From 1 to 7 is $\frac{1}{6}$. Draw a line from 7 through 8, sweep by star from 4 to 1. Dotted line showing the sweep. Shape over and under sleeve as shown in Diagram. Square down from 4 and apply your sleeve measure and get the length; place corner of square on inside seam at hand, and let long arm of square rest on corner where lines 5 and 6 meet, and square for bottom of sleeve at hand; reverse square and draw line up to elbow. Shape as shown in diagram, adding about 1 inch over the elbow for shape on a small size sleeve, and in an extra large sleeve it will have to be reduced all the way from 1 down.

Diag. 5.



SLEEVES---Continued.

HOW TO DRAFT A SLEEVE

FOR A 36 COAT.

First draw a line from A to K.

A to B is $\frac{1}{2}$ and to C is $\frac{1}{4}$.

C to D is $\frac{3}{4}$ inch, in all sizes.

Square out lines B, C and D.

B to E is $\frac{1}{2}$; draw line from B to E.

F is half way between B and E.

Square line up and down from F.

Sweep from B to E by star (2).

Shape top of sleeve as shown in Diagram.

Square down from E to H and measure down length of sleeve.

Place corner of square at H, letting the long arm rest on F.

Square across from H to I.

Turn corner of square around to I and square up to K elbow, and shape sleeve as shown in Diagram, adding about one inch over elbow at K. Hollow the inside seam about $\frac{3}{4}$ inch or whatever shape is desired.

B to G is $\frac{1}{6}$, shape undersleeve as shown in Diagram, crossing line C at 3.

HOW TO CUT A SLEEVE FOR 46 COAT.

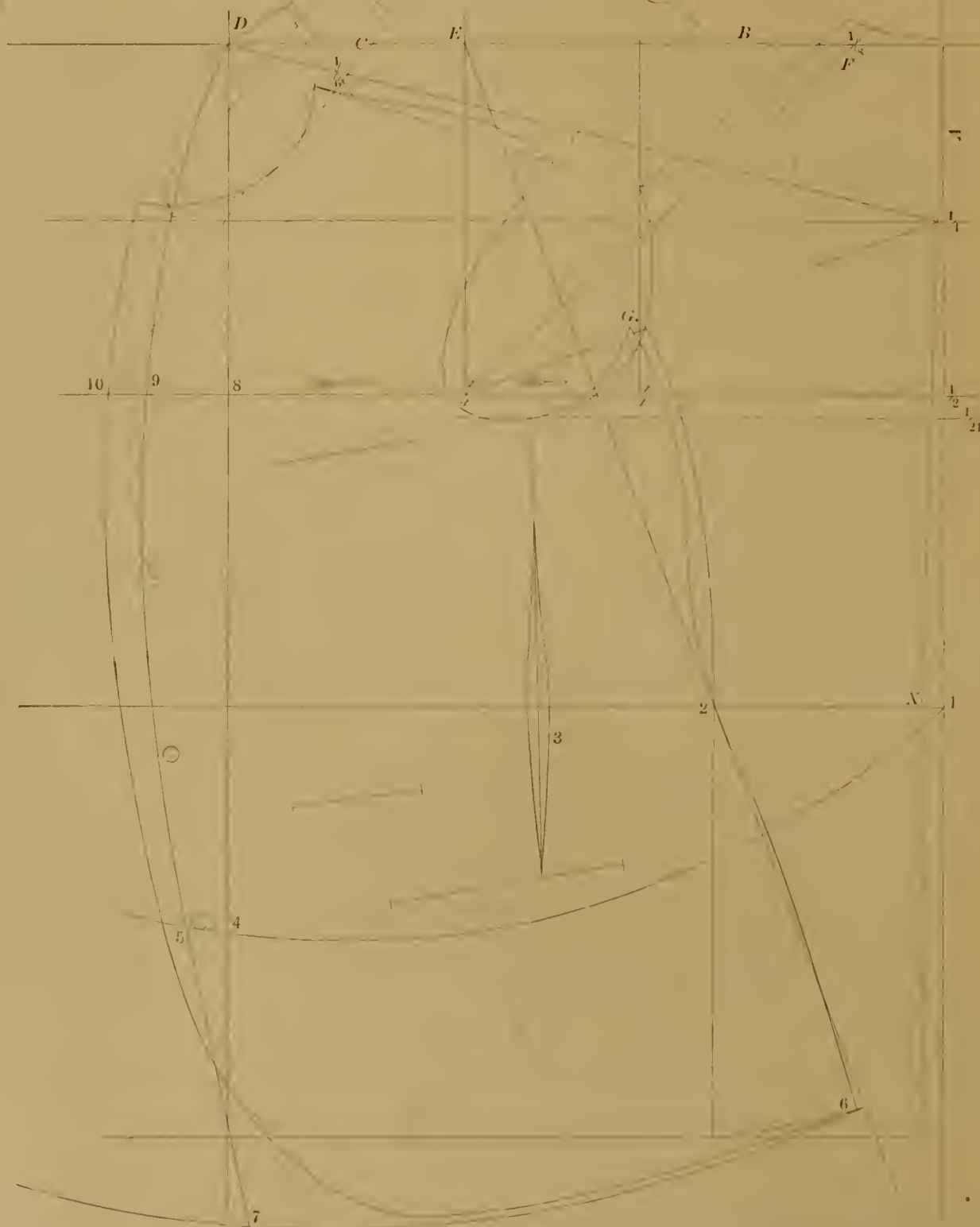
This sleeve is cut on the same principle as the 36, only the upper sleeve must be cut as shown in Diagram, coming inside construction line at C D and adding nothing at K.

In cutting a fat man's sleeve, the following rule will be found to be correct :

Take the armscye measure, say 21, to a 46 coat, 21 armscye and 23, half of breast measure added together, will give a scale of 44; now cut the sleeve on the division of 44, and it will come out the correct size. Of course you will have to use your judgment as to what kind of goods you are cutting, as soft goods will press in more fullness than broadcloth. Therefore a sleeve cut from cloth must be cut smaller than the cheviots.

In cutting overcoat sleeves add at I and K on the outside, the extra width, the inside seam to remain where it is.

Diag. 6



EXPLANATION OF DIAGRAM 6.

The draught of the Sack Coat is very plain, as it is the same as the Frock Coat above the breast line.

First square lines A and B.

Then go down $\frac{1}{4}$, $\frac{1}{2}$ and $\frac{1}{4}$, down to 1, length of waist, and then full length of Coat.

Square these lines out.

Go in on waist line from 1 to X $\frac{1}{2}$ inch.

Square line down, and draw line from X to top of back.

Next, shape back seam.

Go out on breast line to 8, $\frac{1}{2}$ of breast measure and $\frac{3}{8}$ of an inch to allow for what the back seam is hollowed out.

From 8 to front of armscye is $\frac{1}{3}$, and width of armscye is $\frac{1}{4}$.

Draw up these two lines.

From line A to F is $\frac{1}{8}$.

Draw line from F to front of armscye.

Draw line from D to centre of back, and a line from centre of back to front of armscye.

From 1 to 2 on waist is $\frac{1}{3}$.

Square down and you have the width of back.

Then draw a line from E through 2 to 6 for the spring.

Sweep from 1 to 4, by point $\frac{1}{4}$ below C.

Then sweep by same point from 6 to 7, for length of fore part in front.

From 4 to 5 is $\frac{1}{16}$ of breast, and from 8 to 9 is $2\frac{1}{4}$ inches.

Draw front centre line from D, through 9, 5, to 7.

From this line you can make any kind of front.

From 9 to 10 is $1\frac{1}{4}$ inch, and add the same amount at 5 for a Straight Front Sack.

For a D. B. Sack, add $2\frac{1}{2}$ to 3 inches from front centre line 9, 5, according to size of the coat you are cutting, and you must also observe what the prevailing style calls for.

Shape Coat as shown in Diagram, taking out $\frac{5}{8}$ of an inch at G, between back and side body.

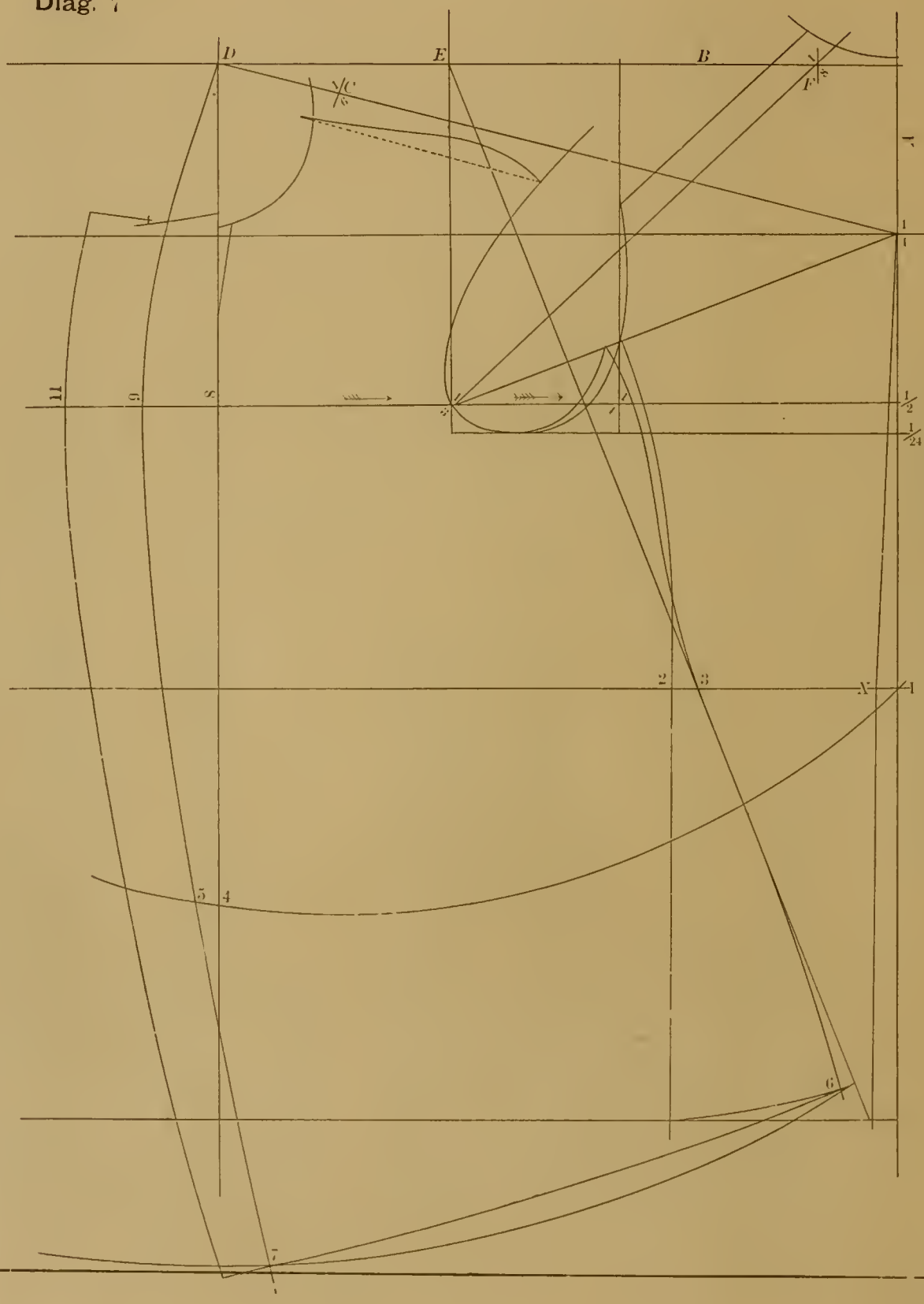
Cut out the back and place F $\frac{1}{8}$ on point $\frac{1}{8}$ below C, and letting the two balance lines run on the top of the other.

Then shape neck gorge and armscye as shown in Diagram, marking off back on shoulder like dotted line.

Add $\frac{1}{2}$ inch over the rounding of shoulder, coming down to dotted line as shown in Diagram.

For a close fitting Coat, cut out a V under arm down to pocket, taking out $\frac{1}{2}$ inch at 3. This Diagram is $\frac{3}{6}$ breast, $\frac{3}{2}$ waist and $\frac{3}{7}$ seat. To regulate the spring, add $\frac{3}{8}$ of an inch at 2 for every inch that the seat is larger than 1 inch more than breast, and take off $\frac{1}{4}$ for every inch that the seat is less than one inch more than the breast.

Diag. 7

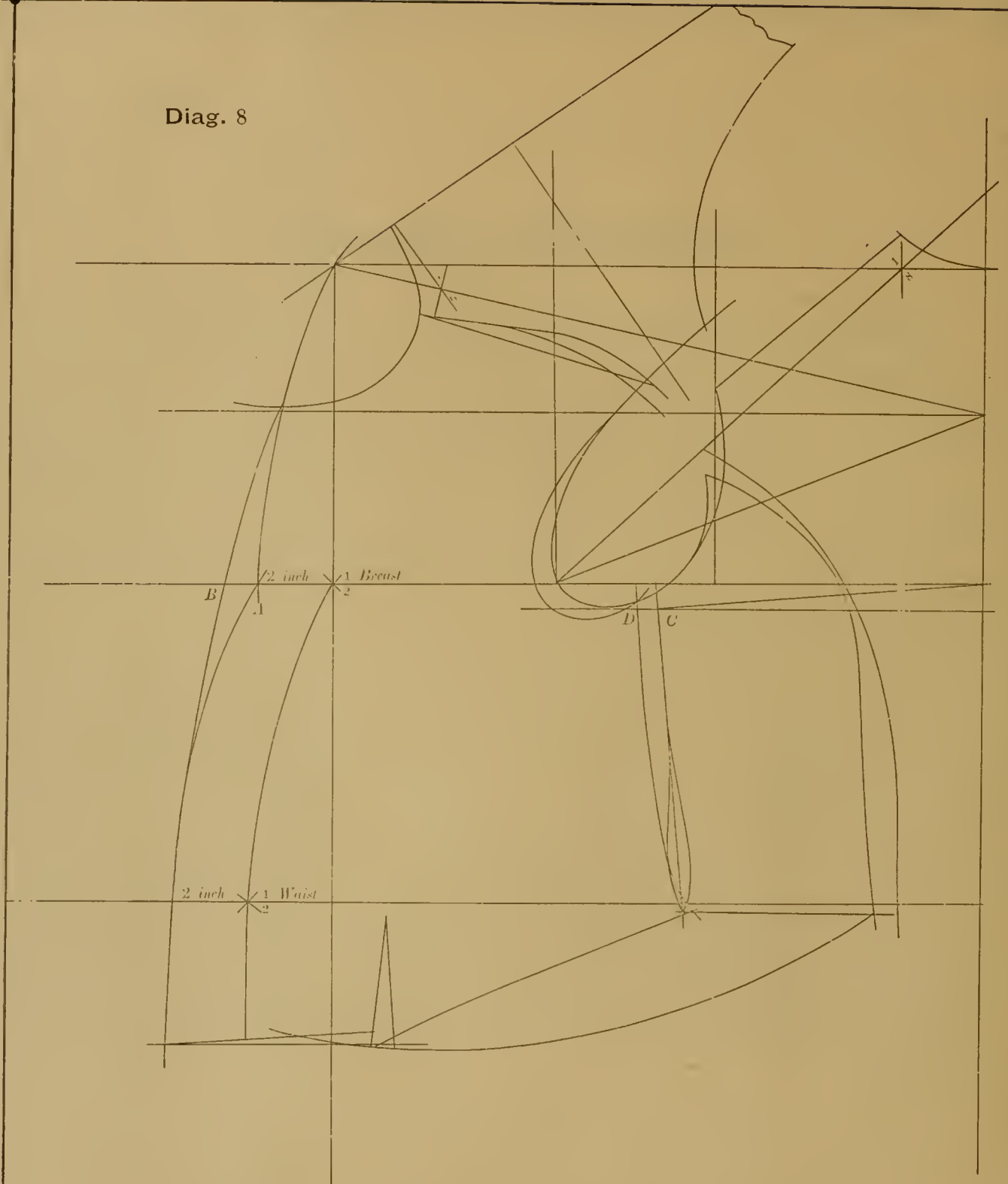


EXPLANATION OF DIAGRAM 7.

This Diagram is of a loose fitting Sack Overcoat. It is draughted the same as Sack Coat in Diagram 6, only there is no V taken out under arm. Make width of back from X to 2, $\frac{1}{3}$, making the back a little wider than in the close fitting Sack; go out from 2 to 3 $\frac{1}{4}$ of Br., and from 4 to 5, $\frac{1}{6}$, from 8 to 9 is $2\frac{1}{4}$ inches, from 9 to 11 is $2\frac{1}{2}$ for a Single, and $3\frac{1}{2}$ for a Double-breasted Coat; go out the same amount at 5, sweep from 1 to 4 by C, and from 6 to 7 by D. This will cut a loose-fitting Sack Coat; regulate the spring as explained in Diagram 6.

For a fat man's Sack add to the front all that your measure calls for, but do not disturb your side seam, as a corpulent man has it all in front. If the customer is extra large over the stomach make changes the same as shown in Frock Coat Draught, Diagram 8. You will now ask why must there be more spring on a loose-fitting coat? Because if it lays too tight on the hip it will hunch up, and you will have a coat with a balloon back in it. A loose-fitting Sack must hang off the hips a trifle to produce a nice hanging coat. A close-fitting coat is different; it can be cut close all the way down. A close-fitting Sack is suitable for cheaper trade, whereas the loose and straight back fitting Sack is only for bon ton trade.

Diag. 8

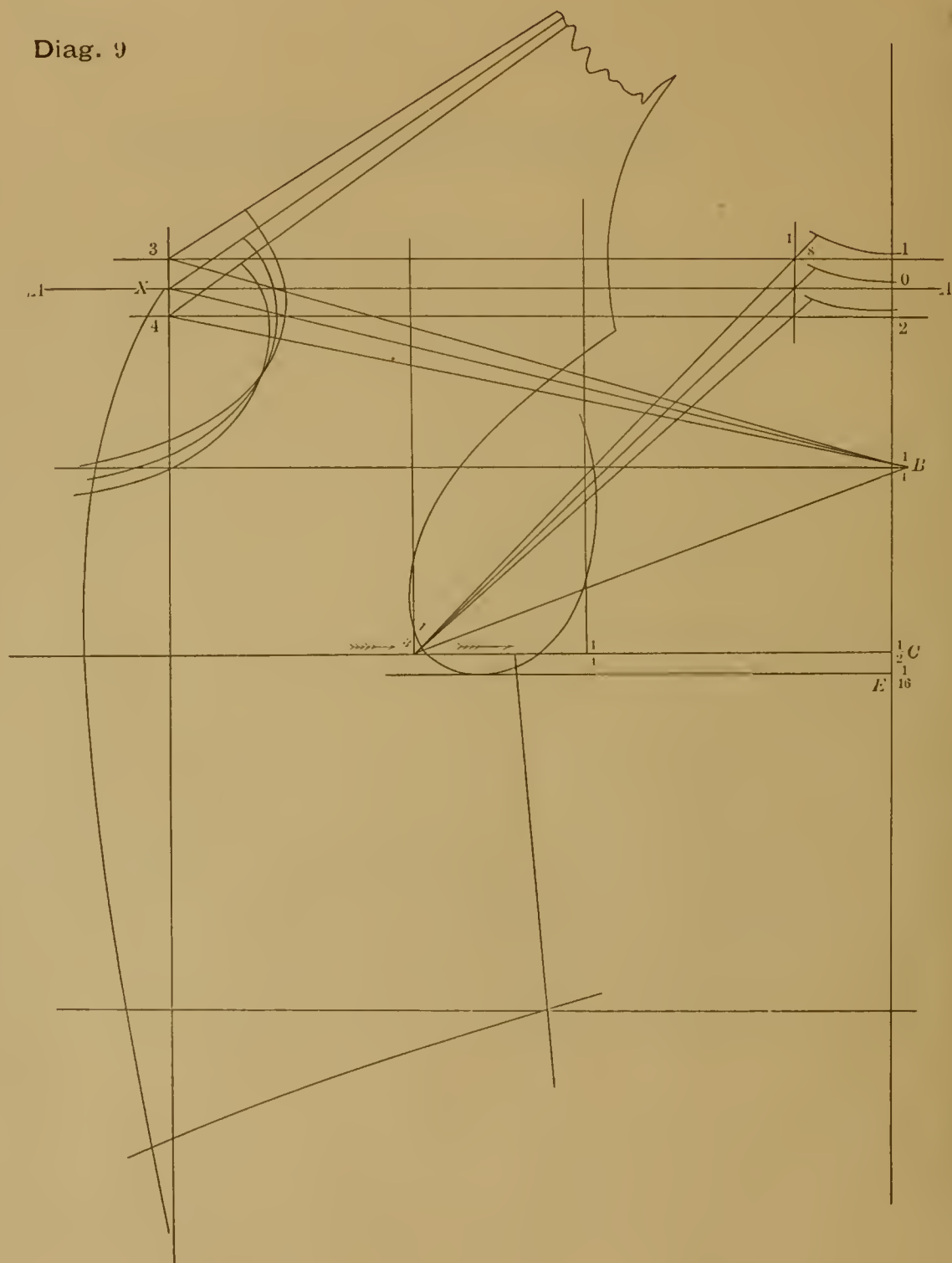


EXPLANATION OF DIAGRAM 8.

HOW TO CUT A COAT FOR A CORPULENT MAN.

Diagram 8 represents a fat man's coat, 44 breast and 46 waist, by adding two inches to breast and sweep up from A, then go out $\frac{1}{2}$ of waist measure and add two inches, then draw line down from A, this will make the chest hollow, and a coat front cannot be cut in this shape. So add all that is needed from A to B making a straight front line, then cut out under arm from D to C, the amount added to front less $\frac{1}{4}$ of an inch. Clear out front of armscye the same amount taken out under arm; also cut off lower shoulder point the same amount. This is the only way to cut a fat man's coat, and get it in proper shape. A sack coat is cut the same way, also the vest. There are very few cutters that can cut a fat man's coat, the reason being that they have an idea that the fat man is built like the lean man, only larger; but this is not the case, as the fat man will in most cases take a 40 back, both in length and breadth. And will require a 44 front, and measure 42 breast and waist. If you will follow my instructions in Diagrams 9 and 10 you will see my way of cutting the Corpulent Coat, by the aid of the self-varying shoulder measure.

Diag. 9

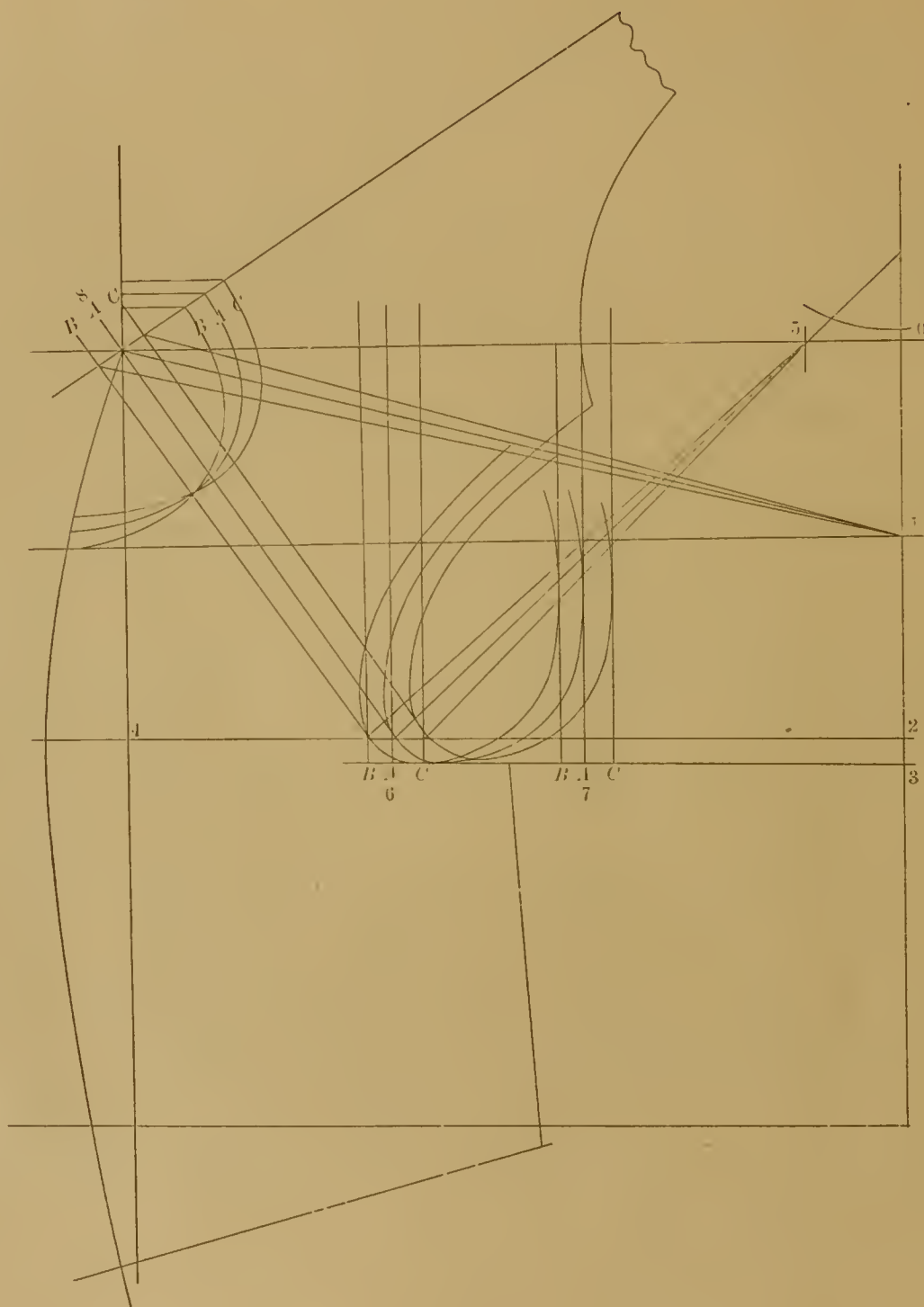


EXPLANATION OF DIAGRAM 9.

THE SELF-YARVING SHOULDER.

The upper shoulder measure is taken from socket bone at O, around under arm up to socket bone. This measure taken snug will be for a 36 coat, 26 inches, or 2 inches more than $\frac{2}{3}$ of the breast measure. Now this is proportion, and you must cut a proportioned coat from O to B, C and E, but if the upper shoulder measure was 28 and the breast 36, you will have a man with long neck and will have to raise the back from O to 1, or making it the proportion $\frac{1}{2}$ of 39 from C to 1. But point B is $\frac{1}{4}$ of 36 from C. Drawing the top line across to front 3. Now understand me right, the distance from C to B is always the same, $\frac{1}{4}$ of breast measure, but the distance from B to A will be increased or decreased as the measure calls for. If you have a 24 upper shoulder and 36 breast, you would have a man with a very short neck, and you would have to reduce the length of top of back to line 2. Making it the proportion of 33 breast from 2 to C, but from C to B is the proportion of 36. On line A, A and X is proportion line; 1 and 3 is high neck line, 2 and 4 is a short neck; the distance from line A to line E, is called the depth of armseye. By looking at Diagram 18 (the Table of Proportions), it will tell you how to apply the upper shoulder measure. Find your upper shoulder measure on the Table of Proportions, then see what breast measure and what depth of armseye you have. It will also give you the length of shoulder strap. This measure taken carefully and applied as explained, will make the coat the right height in neck every time. Be very careful in taking this measure, and remember it is taken snug. This measure will make the coat higher or lower in the neck, but it will not make any more changes, so in order to find the size of the blade, we will have to look up the lower shoulder measure in Diagram 10.

Diag.10



EXPLANATIONS OF DIAGRAM 10.

THE LOWER SHOULDER MEASURE.

The Lower Shoulder Measure is taken from centre of back, between the shoulder, or $\frac{1}{3}$ (of the Upper Shoulder Measure), down from O, around under arm and back to the same place. This measure will be one inch less than the Upper Shoulder Measure, and one inch more than $\frac{2}{3}$ of the breast take a 25 Lower Shoulder Measure, deduct one inch, making it 24; half of 24 is 12, or $\frac{2}{3}$ of half of 36, Breast Measure, from 3 to 6 A is 12 inches, or $\frac{2}{3}$ of breast, or $\frac{1}{2}$ of lower shoulder, less $\frac{1}{2}$ inch. Now, if a man measure 27 lower shoulder, it shows that your man has a large blade, you will have to come forward to B 6, moving the armscye forward, also bringing your shoulder point forward and shortening the front shoulder strap. Now, if you get a man that takes a 23 Lower Shoulder Measure, you will have to come back to line C, moving the armscye back and making the blade smaller; this will also move the shoulder points back to line C at 8. Place corner of square at corner of A 8, letting arm of square come down to point A, at 6, square lines both ways, this will give you the back line, then slide up and down on this line at 8, same as you do on breast line at 6, this clearly illustrates the Lower Shoulder Measure. A is proportion, B shows a large blade, a straighter and shorter shoulder; C shows a small blade, a long shoulder strap and a crooked shoulder. See the proportion table for comparison of shoulder and breast measure.

HOW TO TAKE A MEASURE.

TO MEASURE FOR A COAT.

First determine the full length of waist, and full length of coat, and mark with chalk, then start measuring, take upper shoulder measure from top of neck (socket bone) around under arm and up to the neck again,* then take the lower shoulder measure from centre of back opposite sleeve seam around arm and back to same point ; next measure length of waist and full length of coat, then measure the width of back, then length of sleeve from under arm to hand coming down on hand the length desired for sleeve ; this, the sleeve length, must be taken with the square ; next measure around the armscye and call off the width at hand desired, then measure around the breast, and around the waist, and around top part of hip, where the waist seam of frock coat will come, and around the most prominent part of hip. This completes the measure of all kinds of coats.

TO MEASURE FOR A VEST.

First take the length of roll from the socket bone to where the vest is intended to roll then the full length of the vest, and the length from the socket bone to the hip, for the length of hip, then breast and waist measure. In cutting a single vest, you can take the shoulder measure same as on the coat. All these measures are taken medium close excepting the upper and lower shoulder measure, which is taken snug.

TO MEASURE FOR TROUSERS.

First take the length from waist-band to knee and to bottom on the outside, then take the inside length, then the waist, and then the most prominent part of hip, so thigh, knee, and bottom. In fat men's pants take an extra measure for the height of waist in front, also an extra measure around the upper part of hip, between the waist and seat measure.

NOTES ON MEASURING.

When a customer presents himself to be measured it is well to first take a look at the coat he has on, and also take the length of the waist, and full length of the coat. This will be a guide to the cutter in taking the correct lengths when measuring. After taking these observations, finding out what style of a coat the customer wants, etc., ask him to please remove his coat. See that his vest is buttoned up, and if it sits too loose buckle it up in back close enough to confine the undergarments in their proper place while measuring.

The shoulder measure should be taken snug but not tight. The breast measure should be taken medium easy for a slim man, and quite snug for a fleshy man.

The waist measures must not be taken too tight, as the coat must fit easy (not loose and baggy) around the waist.

The seat measure is taken medium close for a coat, and snug for trousers.

The vest measures are taken over the vest, the same as for a coat, only reduce the measure $\frac{1}{2}$ inch less than the coat, as follows :

Coat 36 B, 32 W.

Vest $35\frac{1}{2}$ B, $31\frac{1}{2}$ W.

PRACTICAL REMARKS ON COAT CUTTING.

REMARKS ON THE FROCK COAT DRAUGHT.

Diagram 2 represents a proportionate draught, 36 breast and 32 waist. In cutting a coat by measure the only change that is necessary is to add to front all that the waist measure calls for, as shown in Diagrams 3 and 8. The rest of the draught remains proportionate. By studying the upper and lower shoulder measure as shown in Diagrams 9 and 10 you can change the location of neck and shoulders according to the shape of the customer you have measured. Always take out $\frac{1}{24}$ between side body and back, and $\frac{1}{24}$ between side body and forepart at waist ; if you get a man with a very small waist, never go back of front line M, but take it out at N, between side body and forepart.

REMARKS ON FULL DRESS COAT.

As a Dress Coat is worn open and not intended to button, it requires less front at waist than the P. A. Frock. One inch added to the waist measure is all that is needed, and to the breast measure $2\frac{1}{4}$ inches or the same as the Albert Coat. To make this coat fit closer, we take out at N $\frac{1}{4}$ of an inch extra. The width of lappel can only be guarded by the prevailing style ; however it should be only wide enough at the waist seam to allow the button hole to go in, say about $1\frac{3}{8}$ inches at waist seam and about 2 inches at the top. The step of the skirt should be about $\frac{7}{8}$ of an inch wide.

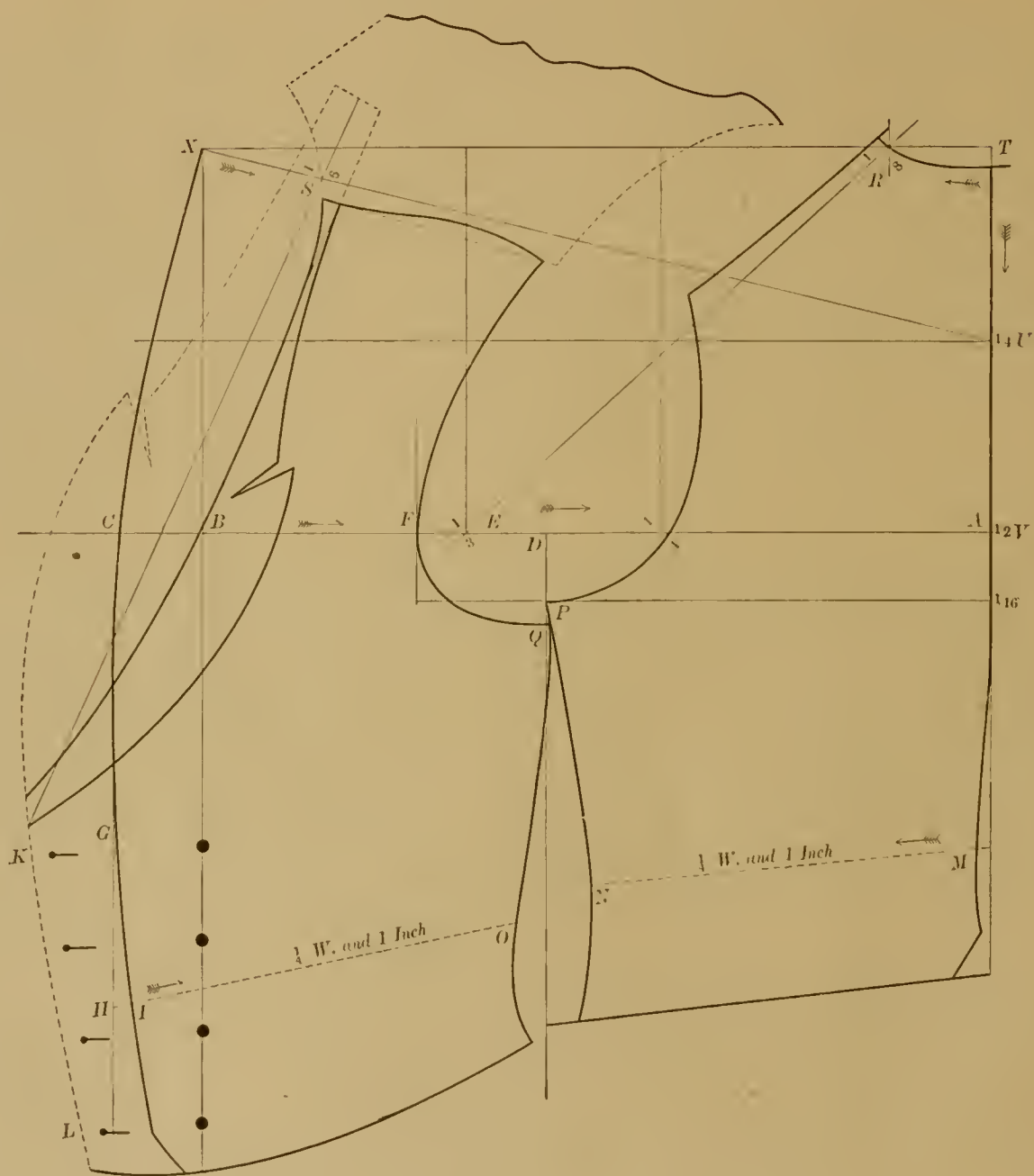
In cutting a fat man's coat, or a coat for a man that stands very erect, I have found the following measures very correct. 1st. Measure the length of shoulder strap from the socket bone to bottom of armscye in front, then go down $\frac{1}{5}$ of the upper shoulder measure on the back between the shoulders, or, if this is too complicated, go down $5\frac{3}{4}$ inches in all sizes, and measure from this point over shoulder to bottom of armscye, this will give a prove measure ; if these two measures come out too long for the front strap, lower the armscye and move down the side body at P, in Diagram 2, say $\frac{1}{2}$ inch, in the most extreme case, then make

forepart $\frac{1}{2}$ inch longer waist, or enough to correspond with the length of the side body. If your measure should call for more than $\frac{1}{2}$ inch it is taken too loose, and in such a case the best thing to do is to stay by the system.

PRACTICAL REMARKS ON VEST CUTTING.

Now in my practice I cut all vests, collar or no collar, the same as shown in the diagram. When I want a collar on the vest, I cut the cilicia collar the shape that I want the collar to be, and sew it on to the edge of the vest, and not press the seam open. This will cut a better collar than the old style. As there is no seam to show through the collar when pressing the vest, however this has nothing to do with the fit of the vest, I merely mention it as I find it an improvement on the old style.

Diag. 11.



EXPLANATION OF DIAGRAM 11.

HOW TO CUT A VEST.

This diagram is laid out by 36 breast and 32 waist. The vest is cut on the same division as the coat.

HOW TO CUT A VEST 36 B, 32 W.

T to U is $\frac{1}{4}$ and to V, A $\frac{1}{2}$.

A to B is half of breast measure.

B to C is 2 inches always.

Square down lines B and C.

Square up line B to X.

Shape front from X to C, G and I, coming in half an inch at H to I.

This will give the front of a normal pattern or a 36 breast and a 32 waist, or any other size where the waist is 4 inches less than breast.

B to E is $\frac{1}{3}$, and E to back of arm is $\frac{1}{4}$, the same as in a coat.

E to P is $\frac{1}{6}$. P to Q is $\frac{1}{2}$ inch.

E to F is one inch and a quarter.

I to O is $\frac{1}{4}$ waist and one inch.

Hollow back half inch at M.

M to N is $\frac{1}{4}$ waist and one inch.

Shape as shown in diagram, cut back out and R $\frac{1}{8}$ on S $\frac{1}{6}$, and shape the shoulder the same as the coat.

In cutting a Double Breasted Vest add to the front from G to K half the distance that you want the button to be in from K and L. Shape as represented in diagram.

HOW TO CUT A VEST 36 B AND 36 W.

This Vest is cut the same as the one just explained. The only change is in the waist.

Now if you will look at the front line in Diagram 11 you will find that for a proportionate waist I take off half an inch from the straight line at H to I. Now for a very small waisted man (no matter how small) I take off nothing more at I, but take it all out in the side at O and N; for a large waist I add $\frac{1}{4}$ inch for every inch that the waist gains on the breast. Instead of reducing the front $\frac{1}{2}$ inch at B, as for a normal figure, add $\frac{1}{2}$ inch, making it in all one inch more, or a quarter inch for every inch that the waist has gained over the proportions of the waist.

When the waist gets larger than breast add front at B, $\frac{3}{8}$ inch for every inch that the waist is larger than the breast.

EXPLANATION OF DIAGRAM 12.

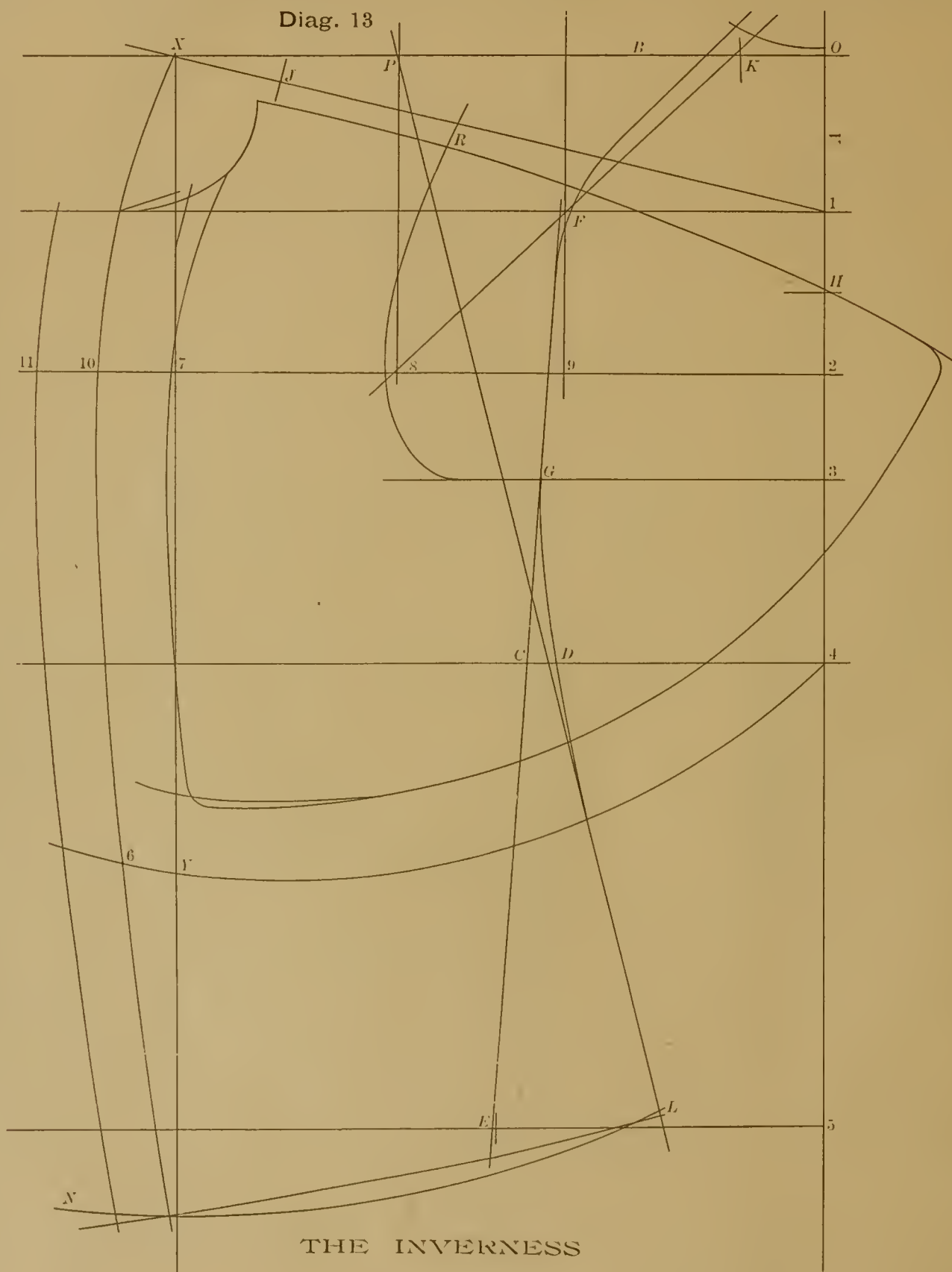
HOW TO CUT NO COLLAR VEST.

The vest is cut the same as the coat, only making the armscye larger. The divisions are marked on the draught. Cut the vest the same as the coat, adding to breast 2 inches, and draw square line down to B. This draught is laid down 36 breast and 34 waist, 2 inches more around the waist than what is called proportion. When waist measure is smaller than 2 inches less than the breast measure, take off $\frac{1}{4}$ of an inch at B, for every inch that the waist is less than 2 inches of the breast, and add to front at B, $\frac{1}{4}$ of an inch for every inch that the waist gains on the breast. Take a man that measures 38 B and 38 W, add $\frac{1}{2}$ inch to front at B. If 38 breast, and 40 waist, add one inch at B. Cut the front same

as fat man's coat, adding on to hollow off chest, and take out under arm. Shape as represented in draft, dropping the back down the same as in Diagram 11, at P Q.

Use upper and lower shoulder measure on the vest the same as on the coat. As all the points are laid out the same as in the coat draft, you will have no trouble in applying the shoulder measures on the vest, the same as on the coat. Cut the vest $\frac{3}{8}$ of an inch lower in the neck than the coat. In cutting a vest without a collar, add $\frac{1}{2}$ inch at neck of forepart, and for a vest with a collar follow the back in shaping the neck, the same as on a coat.

Diag. 13



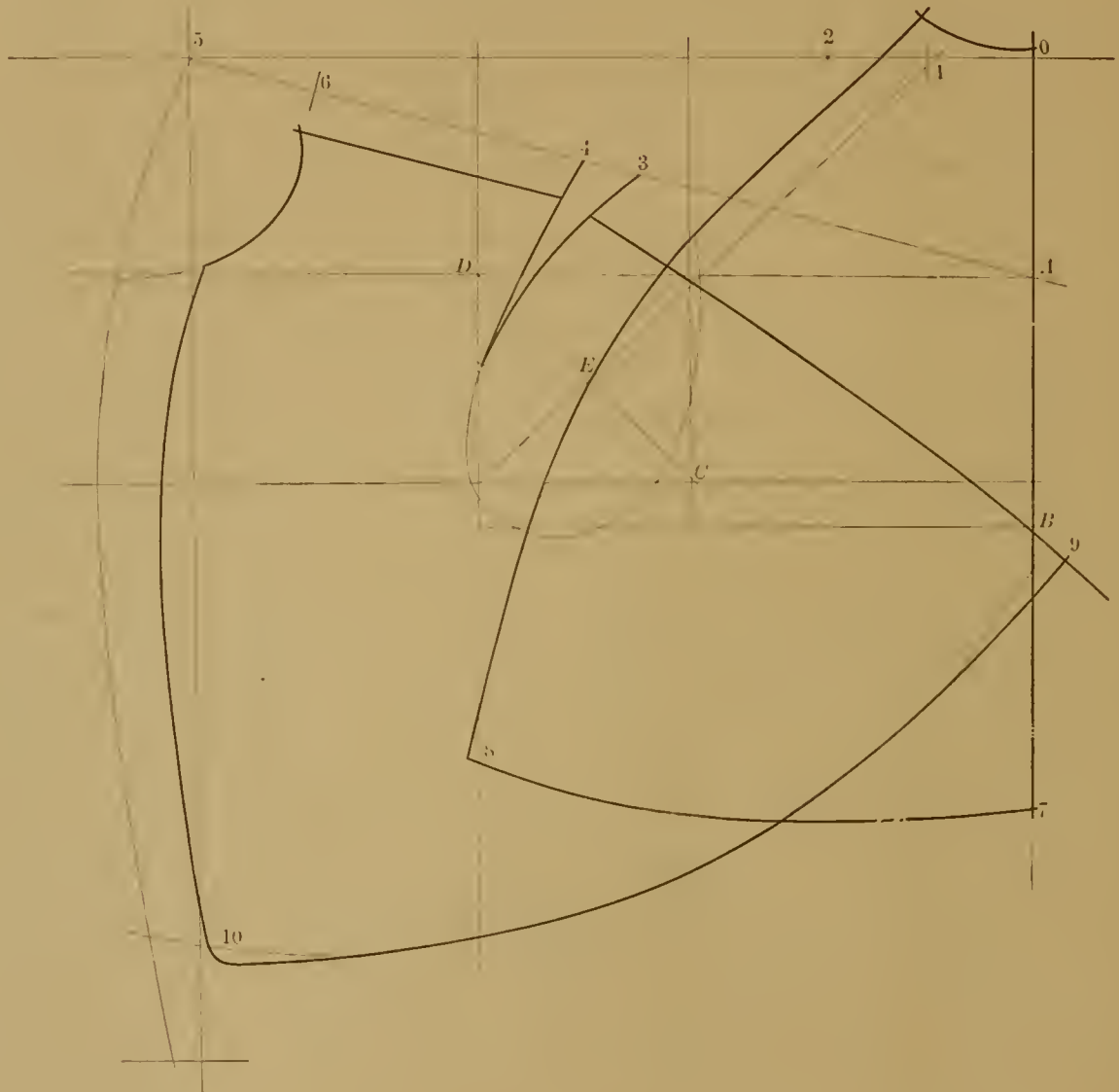
EXPLANATION OF DIAGRAM 13.

THE INVERNESS OR KING WILLIAM OVERCOAT.

This is an over-garment that very few cutters know how to cut; it is an over-garment mostly used as a Dress Overcoat, or in other words it is worn over the Dress Coat, as it slips off and on very easy without "mussing" the under coat.

It is cut almost the same as any other sack coat; first, square lines A and B, from 0 to 1 is $\frac{1}{4}$; from 0 to 2 is $\frac{1}{2}$; from 2 to 3 is $\frac{1}{6}$; from 0 to 4 is the natural length of waist; and to 5 is the full length. Square lines 1, 2, 3, 4 and 5; from 0 to X is $\frac{1}{2}$ of breast measure; square down this line, from 7 breast line to 8 is $\frac{1}{3}$; from 8 to 9 is $\frac{1}{4}$; square lines 8 and 9; from 0 to K is $\frac{1}{8}$. Draw line from 8 to K, from 5 to E is $\frac{1}{2}$ of breast. Draw line from E to F and shape back as shown in Diagram. Rounding the back at F, this completes the back. From C to D is $\frac{1}{10}$ of the hip measure. Draw line from P through D to L; this will give the spring; shape from G to D as shown in diagram; from X to J is $\frac{1}{6}$; sweep from 4 to Y by J; from Y to 6 is $\frac{1}{2}$ of breast measure, making it looser around the hip than the ordinary sack coat; from 7 to 10 is 2 inches. Draw front centre line from X through 10 and 6, then add from 10 to 11 $1\frac{3}{4}$ inches, or whatever lap is desired, and shape front as shown in diagram. Cut back out and place point K on J and finish shoulder the same as any other coat, only making the shoulder seam straight. Make width of shoulder one and one-half inch smaller than the ordinary coat shoulder is; shape arm-hole from R to line 3 at G, as shown in Diagram, and notch the back at G, make same distance from G to L as from G to E; sweep from L to N by X, for length of forepart in front; this will finish the Inverness. Next is the half cape, which is very plain. Drawing line from shoulder to H; H is $\frac{1}{8}$ from 1, or half way between 1 and 2; sweep by J for length and finish as shown in Diagram. In some cases the cape is made to button same as the coat in front, in such a case add to cape in front making it 1 inch wider than centre line, 10 and 6. The collar is cut on this coat the same as any other coat.

Diag. 14



THE CAPE

EXPLANATION OF DIAGRAM 14.

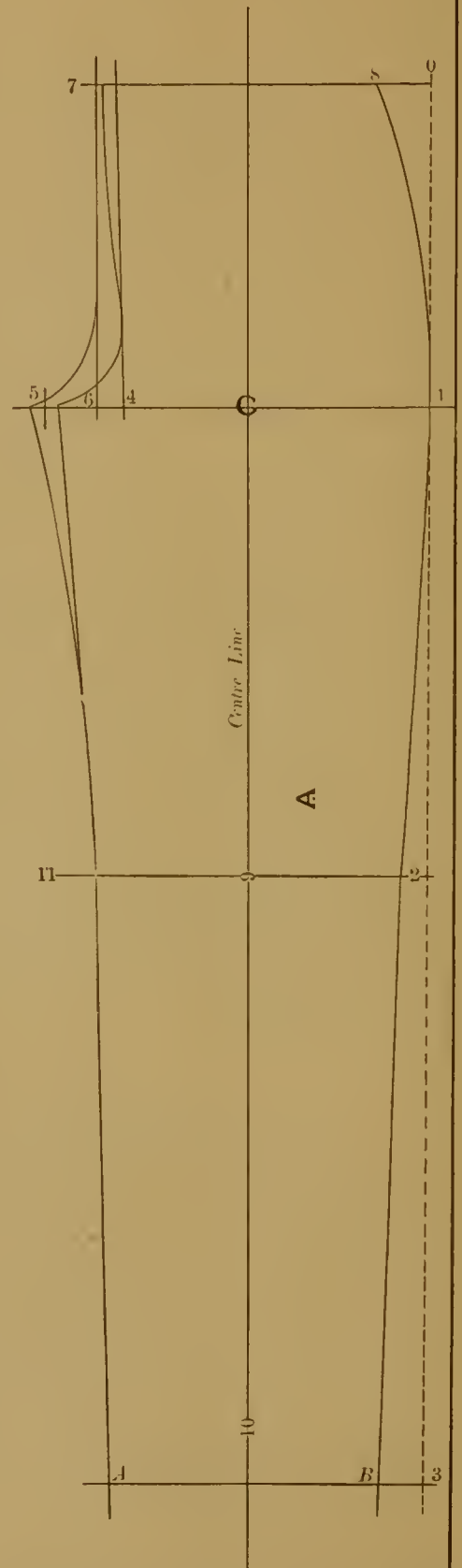
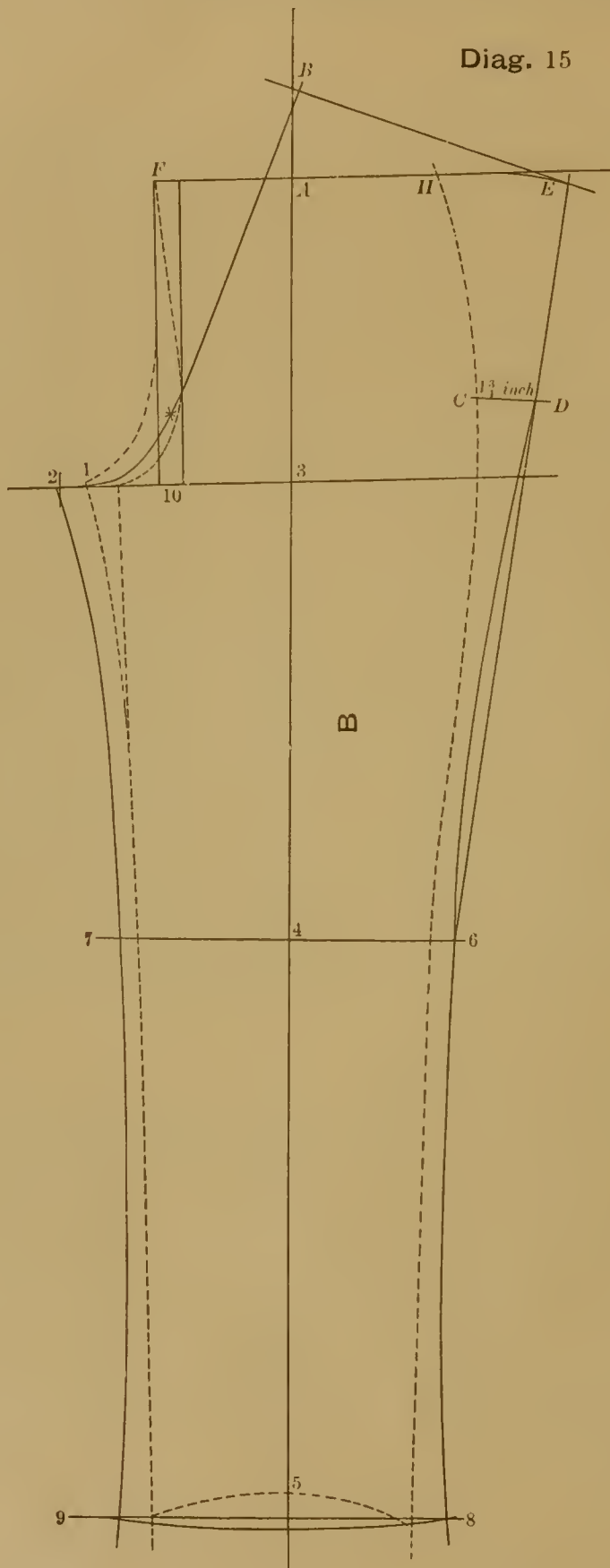
THE CAPE.

The shoulder cape, is at the present time worn quite extensive, over shoulders on the ordinary ulster coat, and made with a $\frac{7}{8}$ of an inch band around the neck, with button holes, and buttons on the under collar of coat, so that it can be buttoned on and off at will. It can be cut from the overcoat pattern or from the ordinary coat draft, it being cut one size larger than the coat in order to make it large enough to go on the top of the coat. It must measure around, opposite the breast line, $\frac{1}{3}$ more than the breast measure. Take for example a 37 coat, the cape wants to be 38, half of 38 is 19, being the half of breast; $\frac{1}{3}$ of 19 is $6\frac{1}{3}$ inches, add $6\frac{1}{3}$ to 19 making it $25\frac{1}{3}$. This the cape must measure to go over the arms, the heavy lines showing the cape. To draft the cape draw first the coat draft, then draw a line from C to D, then shape back part as shown in Diagram, coming through point at E, down to 8, then get length of cape from 0 to 7 from 0 to star at 2, is $\frac{1}{4}$ of breast; sweep from 7 to 8, by star at 2; from A to 3 is $\frac{1}{2}$ of breast less $\frac{1}{2}$ inch, and from 5 to 4 is $\frac{1}{2}$ of breast less $\frac{1}{2}$ inch. Cutting out from 3 to 4 as shown in Diagram, from 0 to B is $\frac{1}{2}$ and $\frac{1}{4}$ same as coat draft. Shape shoulder same as on the coat coming down to 9, crossing line B, measure off same length on forepart to 9 as back is to 8, sweep from 9 to 10, by 6 and finish as represented and the cape is cut.

REMARKS ON THE CAPE.

In cutting a shoulder cape without the cut in shoulder, the back and forepart must be cut on halves, so if the entire width of the cape, opposite the breast line, is $26\frac{1}{2}$ inches the back must be $\frac{1}{2}$ or $13\frac{1}{4}$ inches, and the front $\frac{1}{2}$ or $13\frac{1}{4}$ inches. Be very careful in getting the seam to run on the centre of the arm and shoulder, and have the seam sewed short over the rounding of the shoulder, by taking an easy measure over the arms, around the circumference of the body, just below the shoulder, and adding 2 inches to the measure for making up, and you will find it to come out right.

Diag. 15



EXPLANATION OF DIAGRAM 15.

HOW TO CUT TROUSERS.

The dotted line on Diagram A represents the edge of the paper, or goods, if drafted on the cloth. First draw a square line at o. Now I will draft by the following measures:

$$23-42-32-32-36-18-17\frac{1}{2}.$$

FOREPART.

From O to 2 is 23, and to 3 is 42, being the outside length.

From 3 to 1 is 32, being the inside length.

Square lines 1, 2 and 3.

From 1 to 4 is $\frac{1}{2}$ (on divisions of halves on the square of seat measure.

From 4 to 5 is 18, and from 4 to 6 is one-half inch.

Draw lines 4 and 6.

C is half way between 1 and 5.

Go in the same distance from 3 to 10 as it is from 1 to C, and draw center line.

Then get the width at knee, 18 inches, making the forepart 9 inches or half of knee measure, going out $4\frac{1}{2}$ inches (or $\frac{1}{4}$ on division of fourths on the square). Each way from 9.

Make width at bottom from A to B 8 inches; for $17\frac{1}{2}$ bottom, making it wide enough at bottom to give the forepart a uniform shape all the way down.

Draw line from 1 to 2 and from 2 to B.

Then draw line from A to 11 and from 11 to 5, going in $\frac{3}{8}$ at 5.

Add $\frac{3}{8}$ from 5 for the large side, making the dress $\frac{3}{4}$ of an inch.

From 7 to 8 is $\frac{1}{4}$ of waist measure, or 16 on division of halves on square.

Shape as shown in Diagram, and cut out forepart. This completes the forepart.

BACKPART.

Then for the backpart, place forepart on paper and draw lines 3, 4 and 5; also draw up centre line

From A to B is 1-6 of hip measure.

From 10 to star is $\frac{1}{8}$ of hip measure.

Draw line from B to star.

From 1 to 2 is 1-16 of hip measure.

Shape fork as shown in Diagram.

Add $\frac{1}{2}$ inch at knee, from dotted line to 6, and $\frac{1}{2}$ inch from dotted line to 7, allowing 1 inch over the measure at knee for seams.

Then go out at bottom even each way to make up the measure, and one inch for seams.

From C to D is $1\frac{3}{4}$ inches always.

From crotch line up to C D, is $\frac{1}{8}$ of seat measure in all cases.

Draw line from 6 through D up to E.

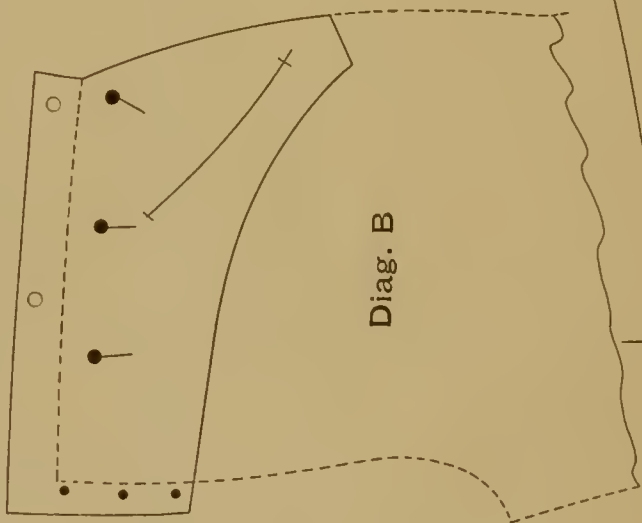
Then measure from F to H and from B to E, making it $\frac{1}{2}$ of the waist and 1 inch.

Shape as shown in Diagram.

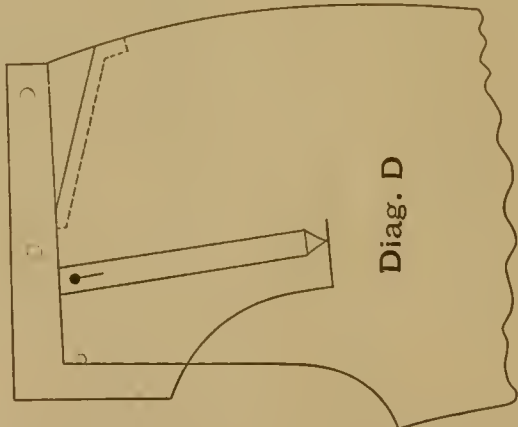
Where a man is very small around the waist and has a large hip a cut in the back will be necessary in order to get the pants small enough around the waist.



Diag. C

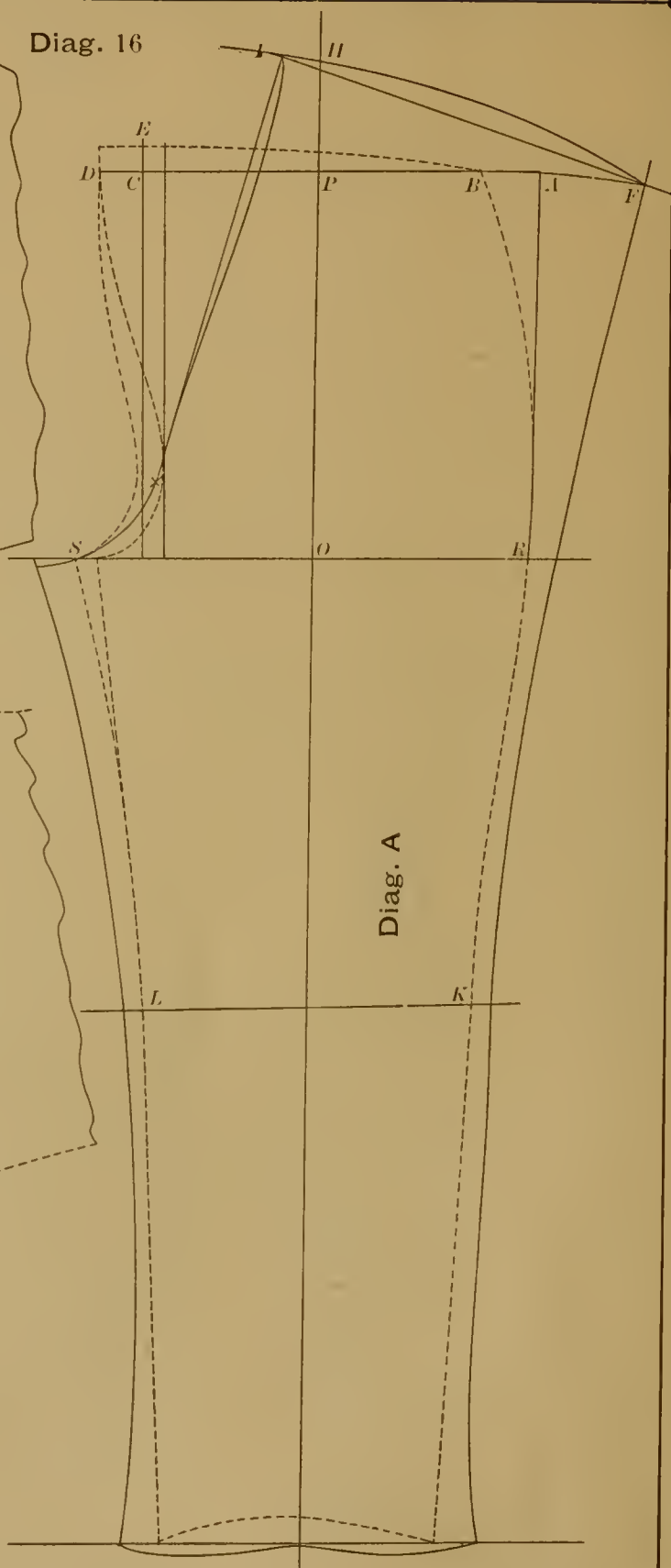


Diag. B



Diag. D

Diag. 16



Diag. A

EXPLANATION OF DIAGRAM 16.

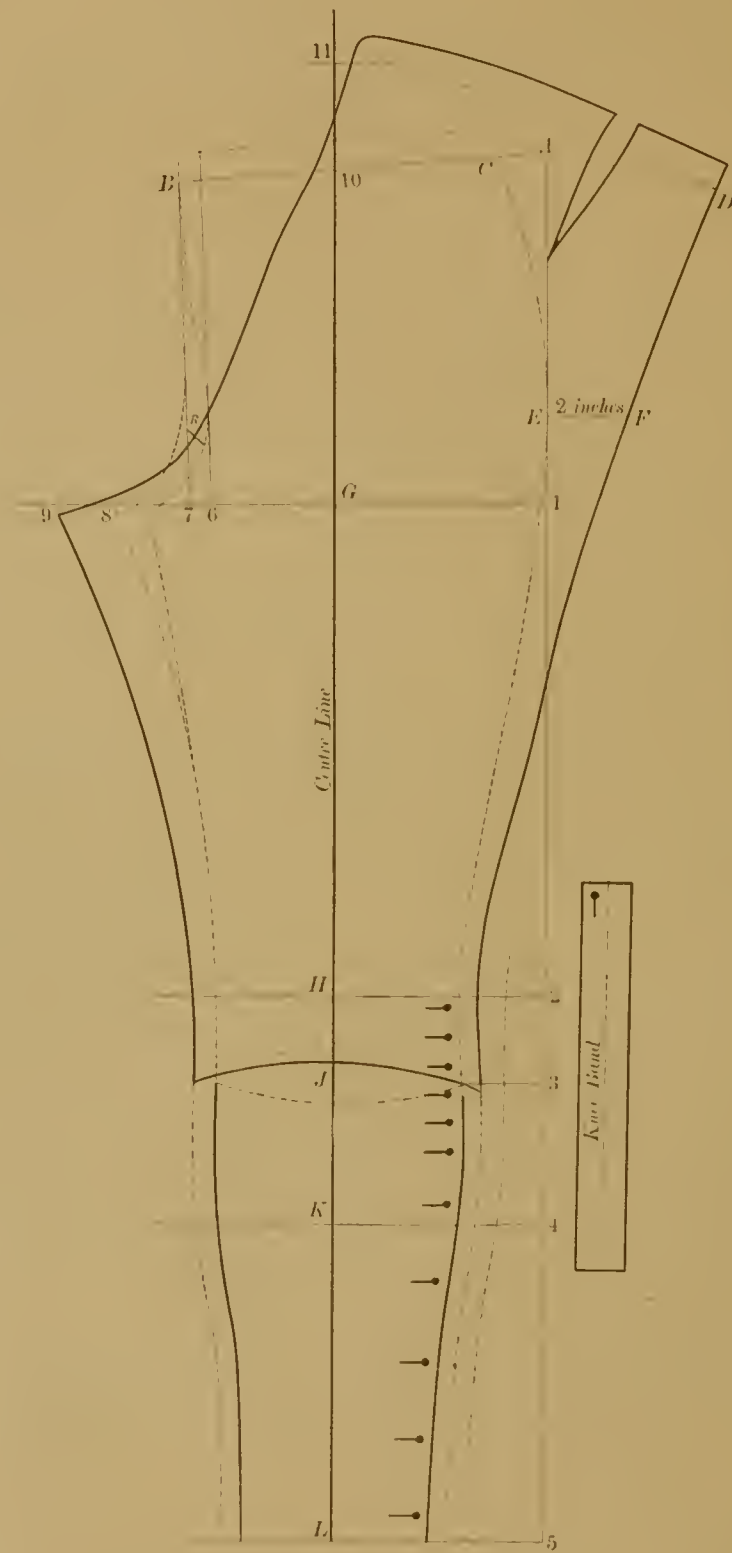
THE FAT MAN'S TROUSERS.

The fat man's trousers are cut the same as any others below the seat, and adding more to the front at waist. Make same distance from B to P as it is from P to C, then go out from B to D $\frac{1}{2}$ of waist measure, then take off $\frac{1}{4}$ the distance from C to D, and add this to B, making the extra width $\frac{3}{8}$ in front and $\frac{1}{4}$ in the side, then add from C to E, $\frac{1}{2}$ the distance from C to D. Drop the fork $\frac{1}{4}$ inch at S, add to back part from H to I, same as from C to D, then apply waist measure same as in ordinary pants. From P to H is $\frac{1}{6}$, or sweep from F to H by L, for height of waist behind.

Diagram B shows the Broad Fall pants the dotted line being the forepart, and the solid line showing the fall bearer and where the pocket should be, if a side pocket is wanted place it in the side seam, same as any other pants. The amount of buttons in the broad fall, being all the way from 4 to 7, as the customer may want it. The fall bearer must be cut high enough to make up for the waist band. Diagram C, showing the back part. The dotted line representing the stitching for the waist band, the opening of the broad fall in the side must be $\frac{3}{8}$ of the rise or from S to E on Diagram A.

Diagram D. This shows the old style of the Small Fall pants, the width of the fall is $\frac{1}{6}$ of the waist measure, and the opening is $\frac{3}{4}$ of the rise, furnished with a band $\frac{7}{8}$ of an inch wide and a triangle sewed out with silk in the end. In other respects they are made like the broad fall pants. This style of pants is not made very often; I have only cut a few riding pants of this style.

Diag. 17.



EXPLANATION OF DIAGRAM 17

DIRECTIONS HOW TO CUT KNEE AND RIDING PANTS.

In making the explanation of this diagram the following measures are used: First, height of waist, 10; length of leg to knee, 14; full length for knee breeches, $16\frac{1}{2}$; waist, 32, seat 36, thigh, 22; knee, $15\frac{1}{2}$; below the knee, 14.

THE FOREPART.

First draw a line from A to 5 or follow the edge of paper.

Square out from A to B.

Go down from A to 1, height of waist (10 inches).

From 1 to 2 in length of leg to the knee and to 3 is just below the knee cap.

Square out lines, 1, 2 and 3.

From 1 to 6 is one-half on divisions of seat (9 inches).

6, 7 is one-half inch.

From 7 to 8 is one-eighth on division of seat ($2\frac{1}{4}$ inches).

Square up lines 6 and 7.

Shape forepart as shown in diagram.

From B to C is one-fourth of waist (8 inches).

G is half way between 1 and 8.

Go in the same distance from 3 to J.

Draw centre line through G, J.

Make forepart one-half of width at H and J at knee, shape forepart as shown in diagram, the dotted lines represent the forepart.

Cut out $\frac{3}{4}$ inch dress as shown in Diagram.

THE BACKPART.

After cutting out the forepart, place it on top of paper and draw lines 1, 2 and 3, also draw up centre line at 10-11.

From 10 to 11 is one-sixth of seat.

From 8 to 9 is one-twelfth.

6, 7 to R is one-eighth of seat.

Draw line from R to half way between 10 and 11 on center line.

Sweep from the outside of knee from C to D for length of backpart, 1 to E is one eighth of seat.

From E to F is 2 inches in all sizes.

Make back one-half inch wider than the forepart at the knee.

From 11 to D is one-fourth of waist and $2\frac{1}{2}$ inches take out a V of one inch, as shown in diagram, and shape the backpart as shown by the heavy lines.

In finishing the knee breeches a band about $\frac{3}{4}$ inch wide should be put on at the knee, the fore part. At J should be cut round (see dotted line) and shrunk in to make room for the knee. The backpart should be hollowed up as shown in the diagram and stretched so as to make it fit nicely just below the knee. Three to four buttons is usually made with opening on the outside seam and one button is placed in the knee band.

If you want to cut regular riding pants to be worn inside the boots, continue the lines down (as shown in diagram) to the ankle. They fit close around the ankle in order to keep them down and not work up. They should be cut about one inch wider at the knee than the knee breeches.

TABLE OF PROPORTIONS

Breast Measure	Upper Shoulder	Lower Shoulder	Depth of Arm Scye	Length of Shoulder Strap	
24	18	17	6 ¹ / ₂	8	From 24 to 31 the Shoulder Measure will be less than Proportion
25	18 ⁵ / ₈	17 ⁵ / ₈	6 ³ / ₄	8 ³ / ₈	
26	19 ³ / ₄	18 ³ / ₄	7	8 ³ / ₄	
27	20	19	7 ¹ / ₄	9	
28	20 ⁵ / ₈	19 ⁵ / ₈	7 ¹ / ₂	9 ³ / ₈	
29	21 ³ / ₈	20 ³ / ₈	7 ³ / ₄	9 ⁵ / ₈	
30	22	21	8 ¹ / ₄	10	
31	22 ⁵ / ₈	21 ⁵ / ₈	8 ¹ / ₂	10 ³ / ₈	
32	23 ³ / ₈	22 ³ / ₈	8 ³ / ₄	10 ³ / ₄	
33	24	23	9	11	
34	24 ⁵ / ₈	23 ⁵ / ₈	9 ¹ / ₄	11 ³ / ₈	
35	25 ³ / ₈	24 ³ / ₈	9 ¹ / ₂	11 ⁵ / ₈	
36	26	25	9 ³ / ₄	12	
37	26 ⁵ / ₈	25 ⁵ / ₈	10 ¹ / ₈	12 ³ / ₈	
38	27 ³ / ₈	26 ³ / ₈	10 ³ / ₄	12 ³ / ₄	
39	28	27	10 ⁵ / ₈	13	From 41 to 48 the Shoulder Measure will be less than Proportion
40	28 ⁵ / ₈	27 ⁵ / ₈	10 ⁷ / ₈	13 ³ / ₈	
41	29 ³ / ₈	28 ³ / ₈	11 ¹ / ₈	13 ⁵ / ₈	
42	30	29	11 ¹ / ₄	14	
43	30 ⁵ / ₈	29 ⁵ / ₈	11 ¹ / ₂	14 ³ / ₈	
44	31 ³ / ₈	30 ³ / ₈	11 ³ / ₄	14 ³ / ₄	
45	32	31	12 ¹ / ₄	15	
46	32 ⁵ / ₈	31 ⁵ / ₈	12 ³ / ₈	15 ³ / ₈	
47	33 ³ / ₈	32 ³ / ₈	12 ⁵ / ₈	15 ⁵ / ₈	
48	34	33	13	16	

From 32 to 40 is Proportion

TABLE OF PROPORTIONS.

The normal or proportionate figure is a man that measures as follows : Height, 5 feet 4 inches; breast, 36; waist, 32; seat, 37; upper shoulder, 26; lower shoulder, 25; inside length of sleeve for this figure would be 17.2, and inside length of leg, 31.

Now if every customer that we get to measure would be in the same proportion we would have no need of using any proof or balance measures. A 36 coat would fit any 36 size man, and everybody would measure just the same proportions as laid down in the opposite side (in Table of Proportions). Understand me right: These measures laid down is not what an average man will measure. It simply tells you in what proportion your customer is that you are cutting a coat for. I will here take a corpulent man that measures 46 breast, 47 waist and 47 seat, his height (in an average of fat men) will be 5 feet 8 inches; his shoulder measure will only be 31 upper, and 31 lower; therefore his coat must be cut lower in the neck. Find 31 upper shoulder measure in Table of Proportions and you will find that 31 shoulder is the proportion of $43\frac{1}{2}$ breast only (see Diagram 9). Now take a tall slim man and he will measure in height 6 feet, and not measure any more than 35 breast, his shoulder measure will be 27, being the proportion of $37\frac{1}{2}$ breast, making the coat considerable higher in the neck than what a normal pattern would be. Now the lower shoulder measure locates the front armscye just the same as the upper locates the height of neck. These measures are fully explained in Diagrams 9 and 10.

The following method is used in finding out what proportion the shoulder measures are in: Take a 26 upper shoulder 2 inches less is 24; add $\frac{1}{2}$ of 24 to itself, making it 36 breast; take one inch off from the lower shoulder measure and use the same method as the upper to find out in what proportions the blade is in.

NOTES ON MAKING GARMENTS.

I will first state that I am a practical Journeyman Tailor as well as a Cutter. My father being a tailor I was born and raised in a tailor-shop, and I pride myself on having been one of Mr. E. Ely's best coat makers when only a mere boy, and I have the work book yet showing where I have made as high as \$45.00 per week making coats; so when I speak of coat-making I take it from real practice and not from guess-work. No matter how good a garment is cut it will not fit unless made up properly.

HOW TO MAKE A COAT.

According to the present style of cutting there need not be so much stretching done as formerly. Stretch the shoulder across about $\frac{3}{8}$ to $\frac{5}{8}$ of an inch according to shape of customer, the armseye to be stretched in front about $\frac{3}{8}$ only, the side body should be stretched a trifle at the hollow of the waist to give the coat a natural curve at the waist. The amount of side body to be stretched cannot be to any given rule, as the cloth has something to do with it. Extra care should be taken in stretching soft goods, as the coat is very apt to get too long in the waist behind. It is always well to give the coat maker warning not to get the coat too long in the back; it is also a good thing to give the length of the waist to the coat maker. The armseye from the back arm seam of the sleeve around the blade to the centre under the arm should be held in a trifle by putting in a linen thread or a stay tape. The blade at this portion of the body is rounded and the holding in of the back part of armseye conforms to the natural shape of the body, preventing the coat from drawing or wrinkling at the top of side body when the arm is in motion. The under sleeve should be put in a trifle full over the side body, and the seam should not be pressed open over the side body; this will allow the seam to fall gracefully over the side body and give it length enough when the arm is thrown forward. The collar should be put on easy, as a short collar will spoil the fit of the coat. The first thing to do when a coat dont fit is to look after your collar, and if short take it off before altering the coat elsewhere. The skirt should be put on front $\frac{1}{2}$ to $\frac{3}{4}$ of an inch full to the forepart over the hip. In a P. A. Frock

or Dress Coat the lappel should be sewed on even below the roll, as a short lappel will make a bad looking front. There should be a great deal of care taken in basting under the canvas. A good many tailors have the idea that the canvas should be tight in the breast of the coat; this is a very bad practice, as it will never make a good front. The canvas must be fully as large as the goods to make a good shaped front; press your canvas in good shape before basting under. In padding your breast do so from the lining side and use fine cotton and take short stitches on the side that goes next to the goods and do not draw the stitches tight as it will draw up the canvas and show through the broadcloth and dress worsteds. The stay tape should be put on fair, never draw it in very much as a short front edge is just as bad as a long one; if raw edge stitch close up to the stay tape; if bound there is no need of having any stay in the edges as it only makes them heavy and clumsy looking. There should be more care taken in basting on the facing on all coats than the tailors usually do. The facing should not be held on too full as it will not stand press, but come back when exposed to the damp air. In overcoats the facing is very apt to get too short as the front edge has been held in with the stay tape. There should be a plait laid on the forepart lining at the waist seam, also in the centre of back and on the skirt lining over the hips. The neck pad should be put on easy. It would make a book of 300 pages if I was to describe all the points in coat making, so I will only give a few hints in pressing.

HOW TO PRESS A COAT.

The old style of hard pressing a coat before sponging the gloss off is a mistake, as it will take a good deal more steam to get the gloss off after allowing the garment to get cold, therefore, hard press with a fairly hot iron and immediately follow with the sponge cloth and a red hot iron, and you will not only have an elegant pressed coat, but will do the pressing in half the time. The light weight goods and German cloths will stand very little sponging; they must be dry pressed. I must here explain why this mode of pressing is superior to the old style. Take for example the canvas breast, and sponge hard on it, and

you will find that it all puckers up, but if you hard press it first, and then sponge it, you will have sufficient heat in the canvas to dry up the steam, and the canvas will not pucker.

HOW TO DRY PRESS.

Take a piece of broadcloth and a piece of linen Holland and sew the two together, lay the cloth side to the garment you press; wet the linen with a sponge and press dry, and you will have your garment dry pressed without getting it glossed. Farmer satin or other smooth faced goods, will take the place of broadcloth, but the cloth is the best.

VEST MAKING.

On the subject of vest making there is not much to be said. So far as the putting the vest together, it is easy to learn; in joining it up in the sides, be sure and have the back and forepart even at top under arm, also even at the neck, in putting the shoulders together, the back should go on easy to the forepart. A good vest maker is one that is very neat and tasty, with some artistic skill in forming a good shape in the collar, breast and shoulder. The front edge should be held in very little.

HOW TO MAKE TROUSERS.

It does not require an extra fine sewer to be a good pantaloon maker, but he should have some artistic skill in shaping the legs, the pantaloons require no stretching before sewing them up; put them together as they are notched and then press them in shape, never glue the buttons with rubber tissue, as it will spoil the button after one week's wear, and you will have trouble with them. In very light weight goods, a strip of canvas cut on the bias should be put under the turn-up at bottom; in joining the pants up, the seam should be stretched about $\frac{1}{2}$ inch on the back part in fork, to make the pants easy in stride.



ADVICE TO YOUNG CUTTERS.

Young cutters should not allow themselves to become involved in the mechanical repetition of producing and reproducing the same thing from day to day. The art of cutting is nothing more nor less than to please the customer, and in so doing your employer is also pleased, and you will have the reputation of being a good cutter. The position as a cutter, naturally brings you in contact with all classes of people, and a cutter never should allow himself to argue with a customer on any subject. It requires lots of attention from the cutter to the customer, as most customers have a weakness for attention, and if attended to in a genteel and polite manner (not dudish or foppish) the customer will have less fault to find with the fit of the clothes, as well as the price paid for them. There is nothing to be lost by being civil and polite to everybody, but everything to be gained, even though you do not care for the customer's trade. When a boy, I heard a remark from a tailor to a customer who was abusing him most shamefully about a coat; the customer finally asked the tailor, "Why don't you get mad? I think I have insulted you enough." The tailor answered, "No, you have not insulted me." "Well, how is that?" the customer asked. "Well, you see, Mr. Brown," the tailor replied, "a gentleman would not insult me, and one that is not a gentleman cannot, as I take no notice of him." Now, whenever a customer has acted ugly, I have always remembered this remark, and it has done me lots of good. To be a successful cutter, one must study human nature; study etiquette and how to be graceful, never allow yourself to get excited; never allow yourself to insult anybody in your business, and don't allow anybody to scare you by telling you that they have got "a h - l of a fit;" it may not be half as bad as the customer makes it. A cutter should avoid the use of tobacco in all its forms, never smoke in the store, and avoid intoxicating beverages, hold your breath when in front of a customer, he don't like the smell of whisky, onions, limberger cheese, etc., he may be fond of all these things himself, but he don't like the smell of it from anyone else. A cutter is considered an artist, and is a gentleman, and if you don't think anything of yourself, how can you expect anybody else to think anything of you. So a successful cutter must be a gentleman in every respect, as well as being a good cutter. The two combined makes an A 1 cutter and such a man can always secure a good position and good pay.



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